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**Sullivan**

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(45) **Date of Patent:** **\*Nov. 13, 2001**

(54) **PERIMETER WEIGHTED GOLF BALL WITH VISIBLE WEIGHTING**

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(List continued on next page.)

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(\* ) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

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This patent is subject to a terminal disclaimer.

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(21) Appl. No.: **09/431,533**

(57) **ABSTRACT**

(22) Filed: **Nov. 1, 1999**

**Related U.S. Application Data**

(63) Continuation-in-part of application No. 09/049,868, filed on Mar. 27, 1998, now Pat. No. 5,984,806, which is a continuation-in-part of application No. 08/782,221, filed on Jan. 13, 1997, now Pat. No. 6,015,356.

(60) Provisional application No. 60/042,428, filed on Mar. 28, 1997.

(51) **Int. Cl.**<sup>7</sup> ..... **A63B 37/12**

(52) **U.S. Cl.** ..... **473/373; 473/337**

(58) **Field of Search** ..... 473/365, 377, 473/378, 52, 53, 353, 612, 607, 604, 605, 570; 40/327

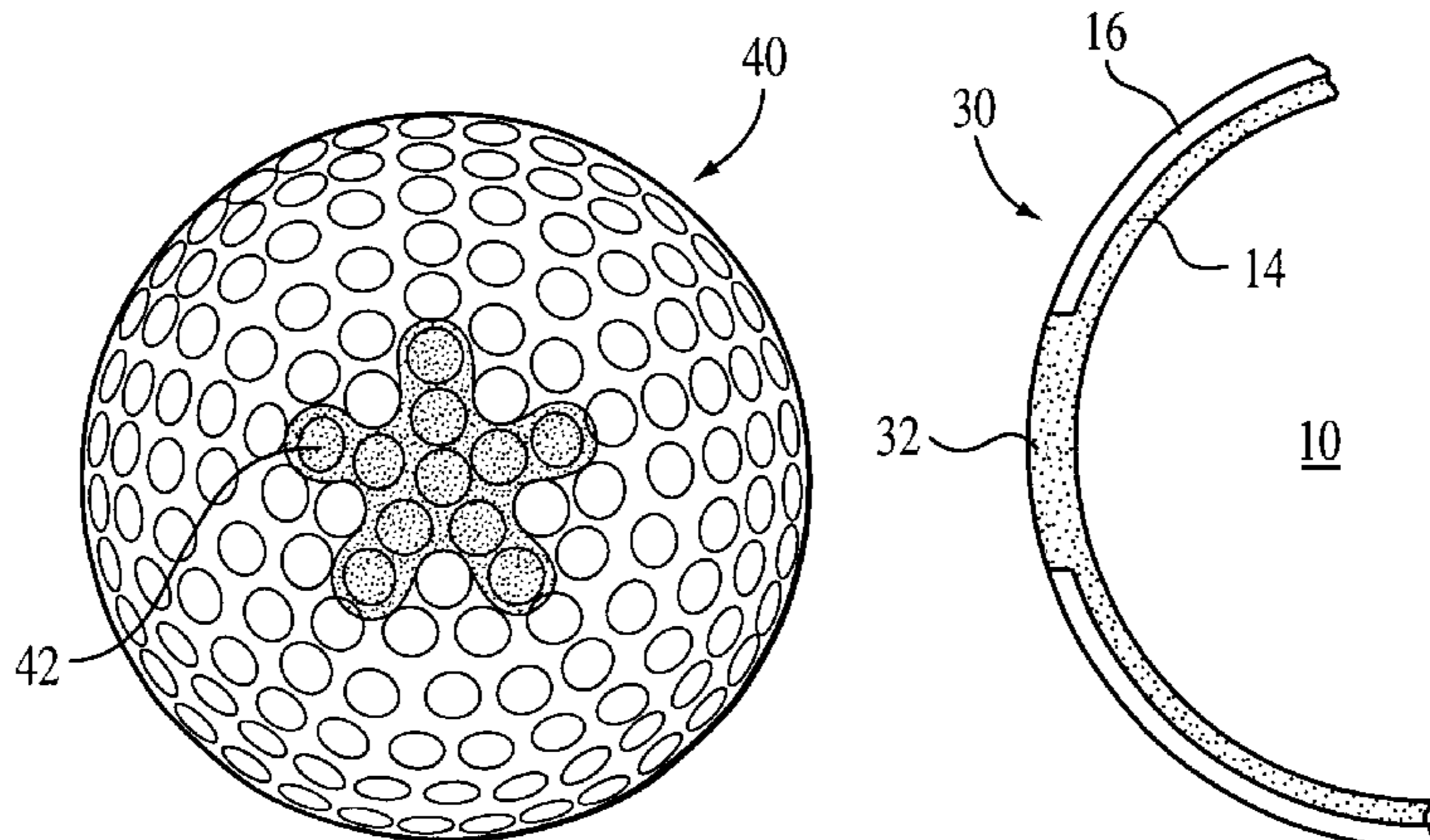
The present invention is directed to improved multi-layer golf ball compositions and the resulting regulation balls produced using these compositions. In this regard, a smaller and lighter core is produced and metal particles, or other heavy weight filler materials, are included in the cover compositions. This results in a molded golf ball exhibiting enhanced perimeter weighting. Preferably, the particles are included in a relatively thick inner cover layer (or mantle) of a solid, three-piece multi-layered golf ball. In another preferred version, one or more patterns of weighting material are incorporated in the ball, and most preferably along the outer periphery of the ball so that the pattern is visible along the ball's exterior. Particularly, one or more transparent viewing windows are provided along the outer surface of the golf ball to reveal weighting material disposed within the ball. The size and weight of the core is reduced in order to produce an overall golf ball which meets, or is less than, the 1.62 ounce maximum weight limitation specified by the United States Golf Association. It has been found that the present invention produces a golf ball with an increased moment of inertia and/or a greater radius of gyration and thus generates lower spin. This results in a golf ball exhibiting enhanced distance without substantially affecting the feel and durability characteristics of the ball.

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**20 Claims, 10 Drawing Sheets**



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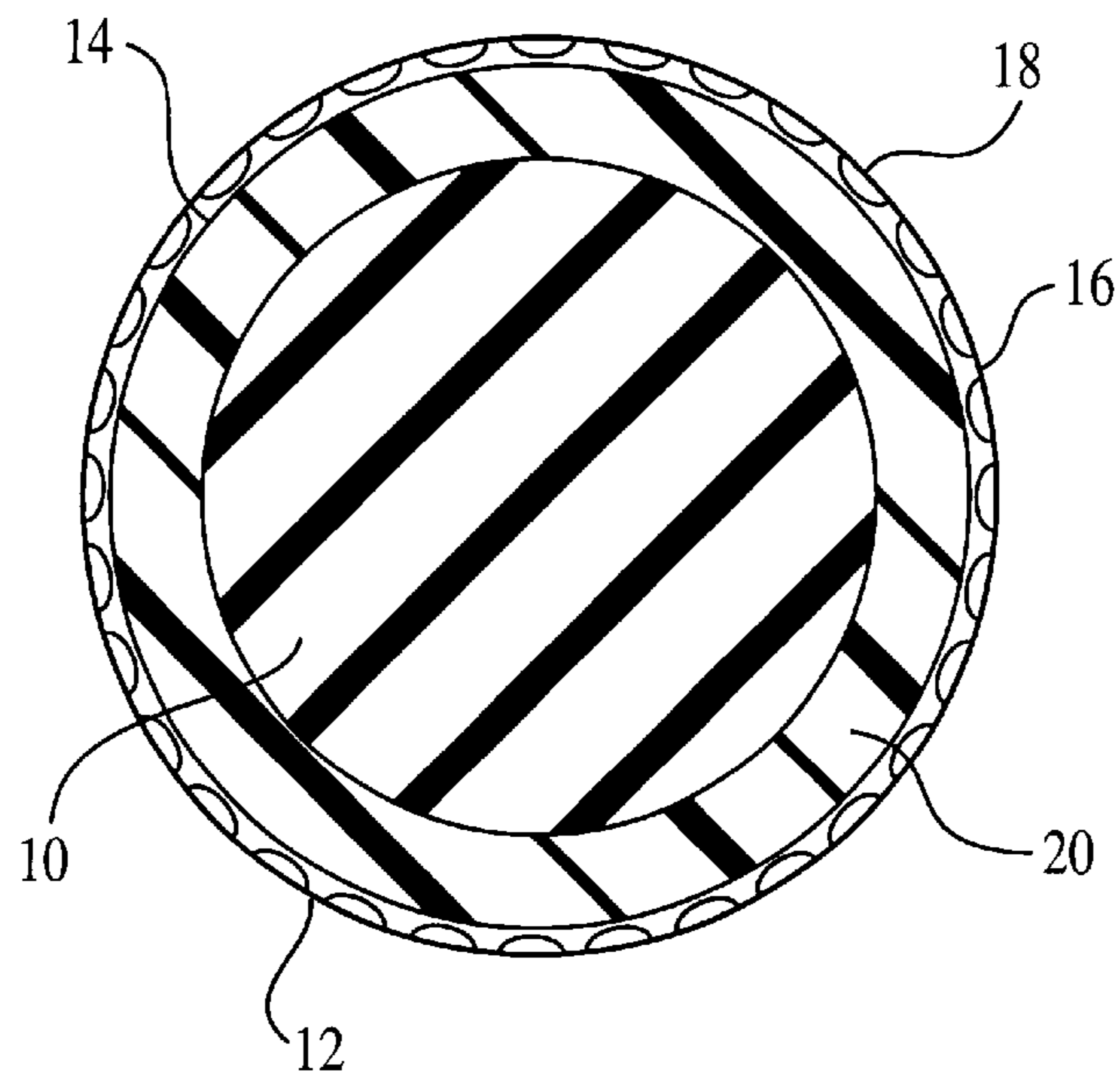


FIG. 1

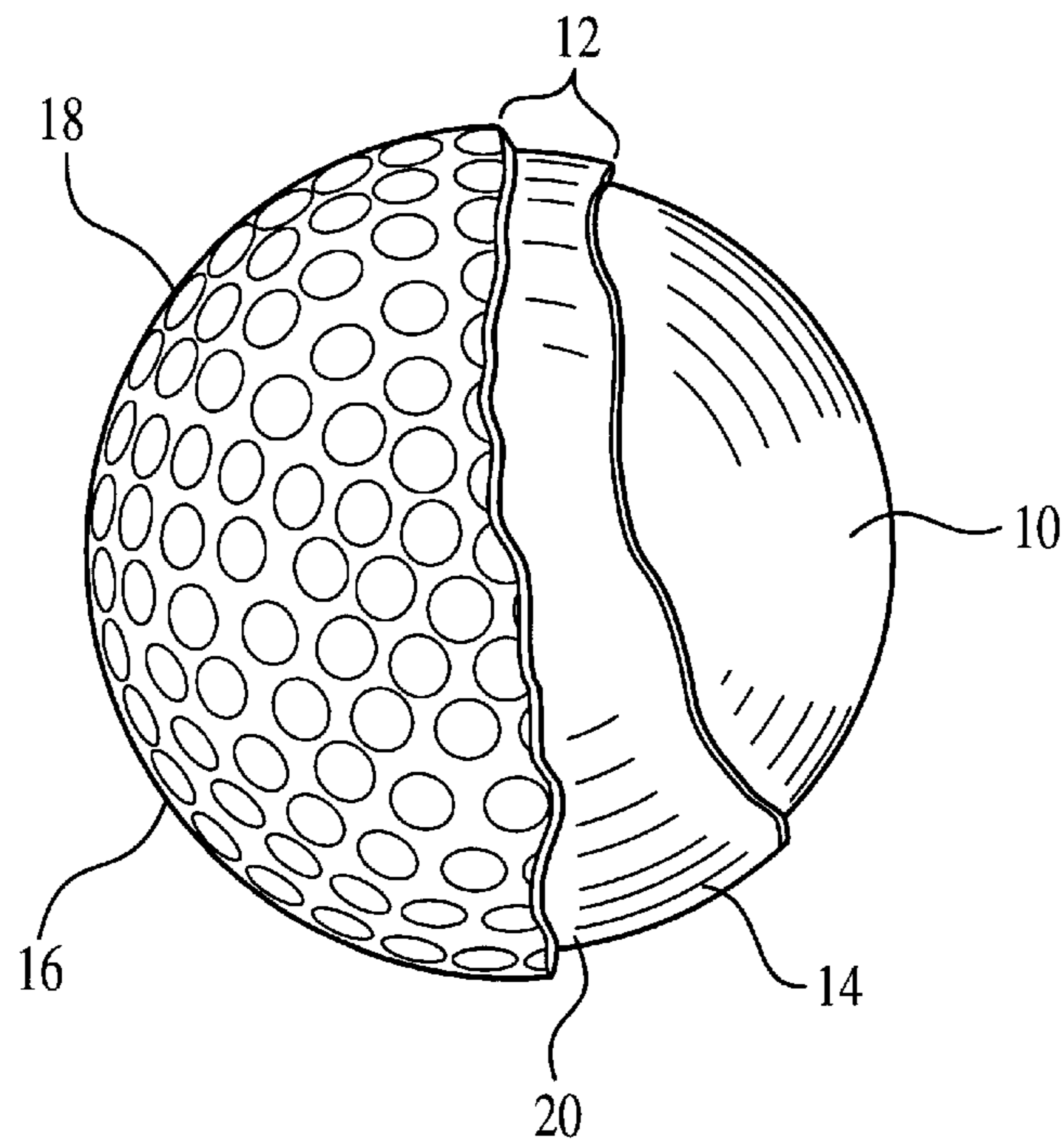


FIG. 2

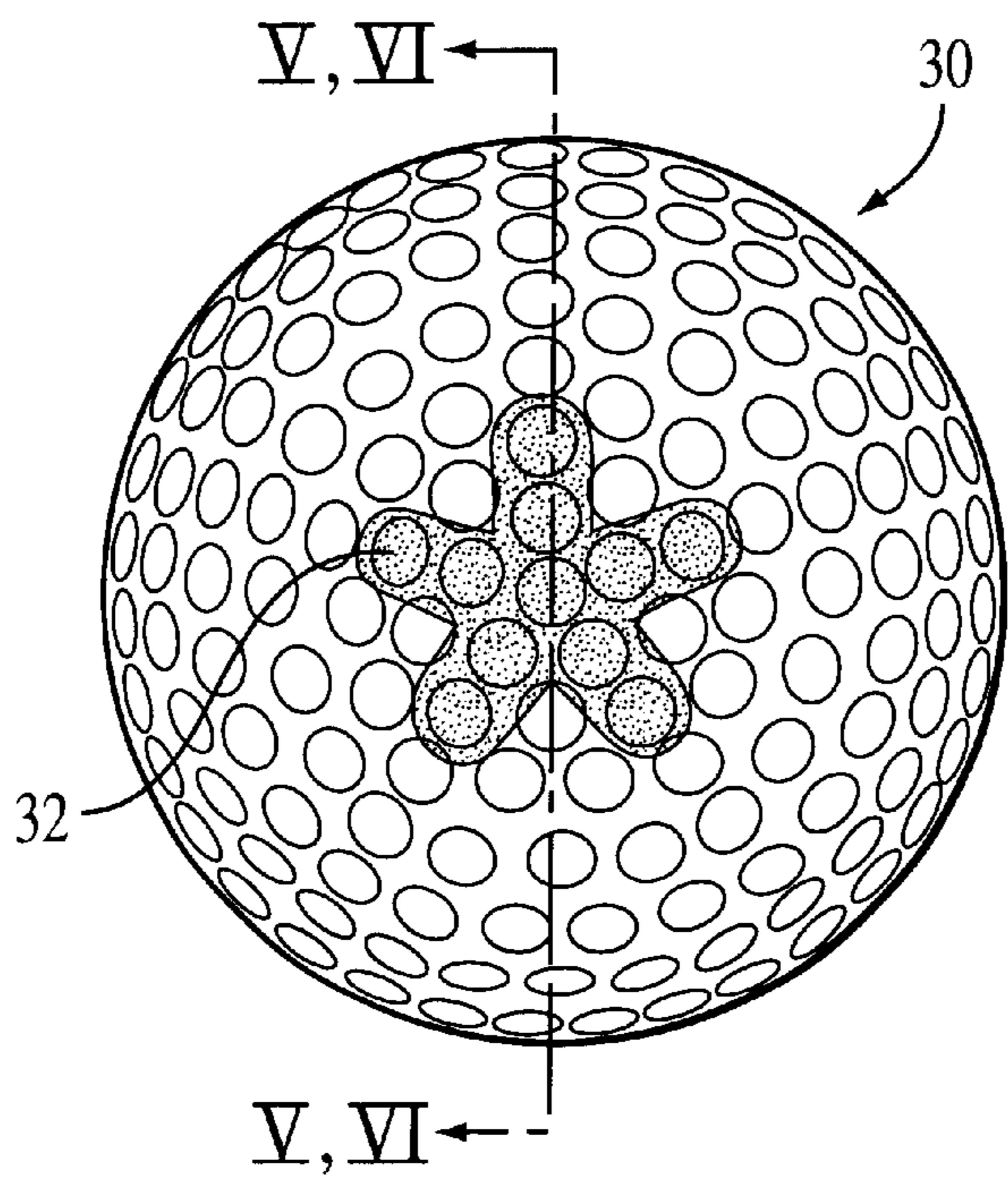


FIG. 3

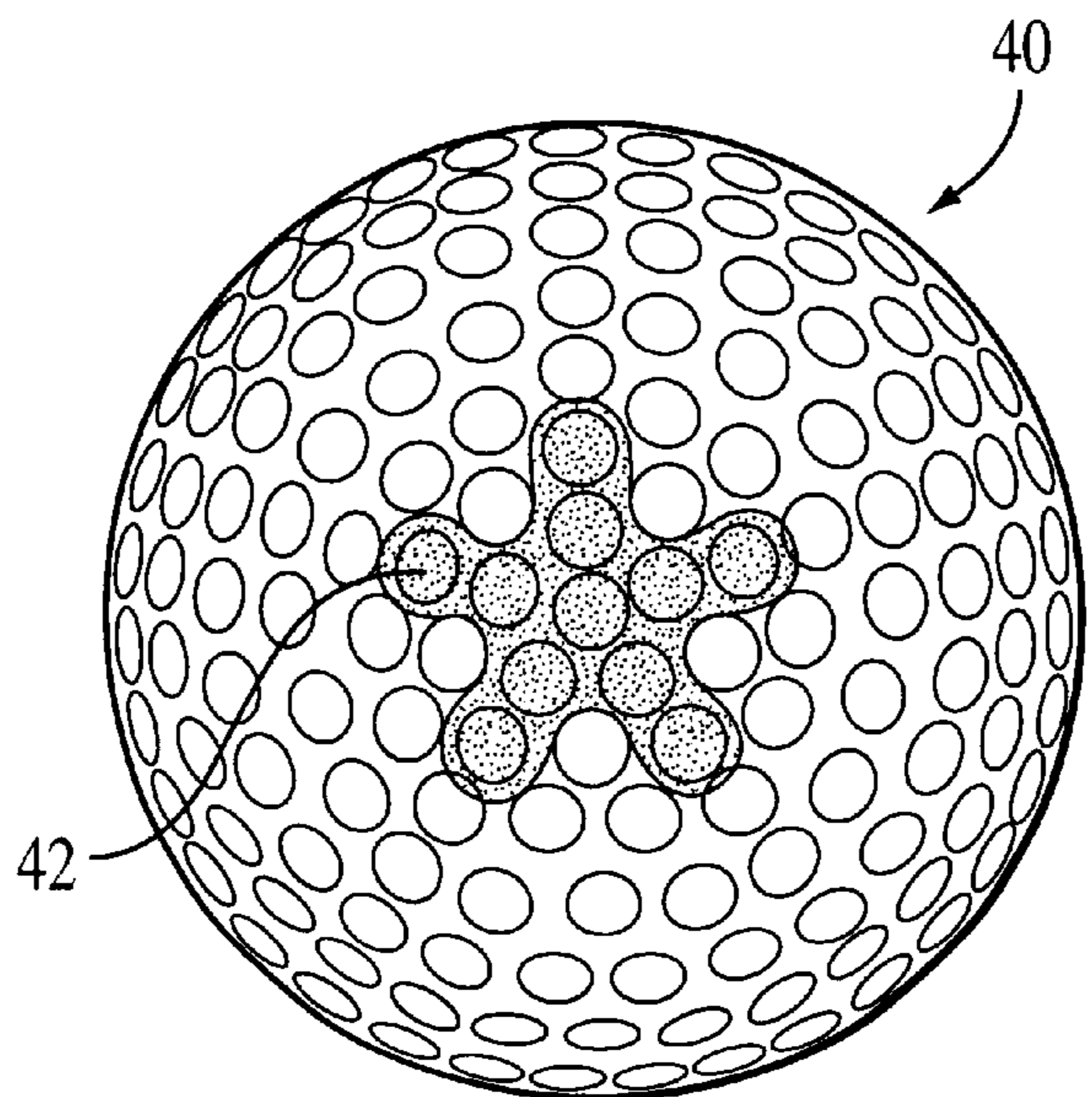


FIG. 4

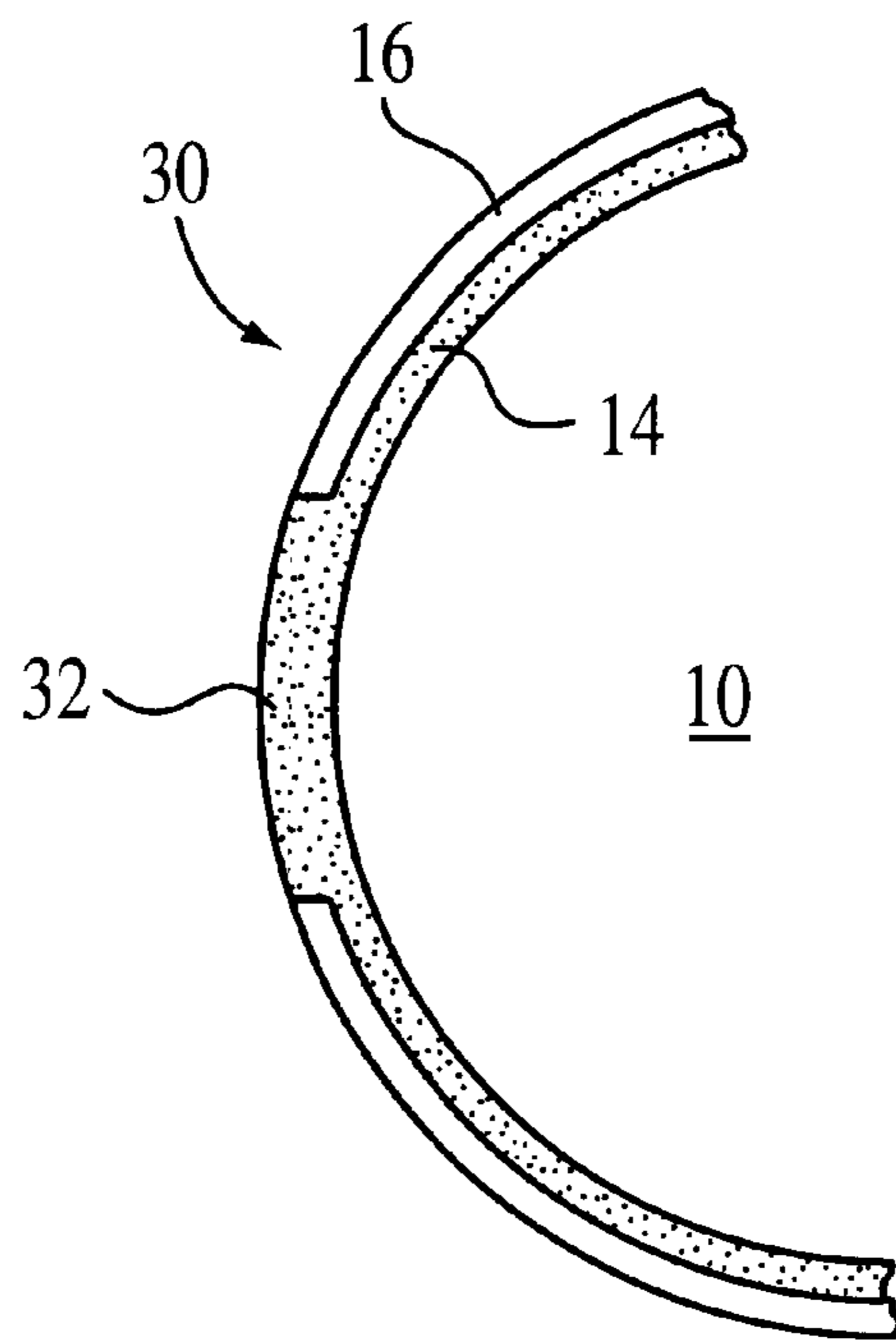


FIG. 5

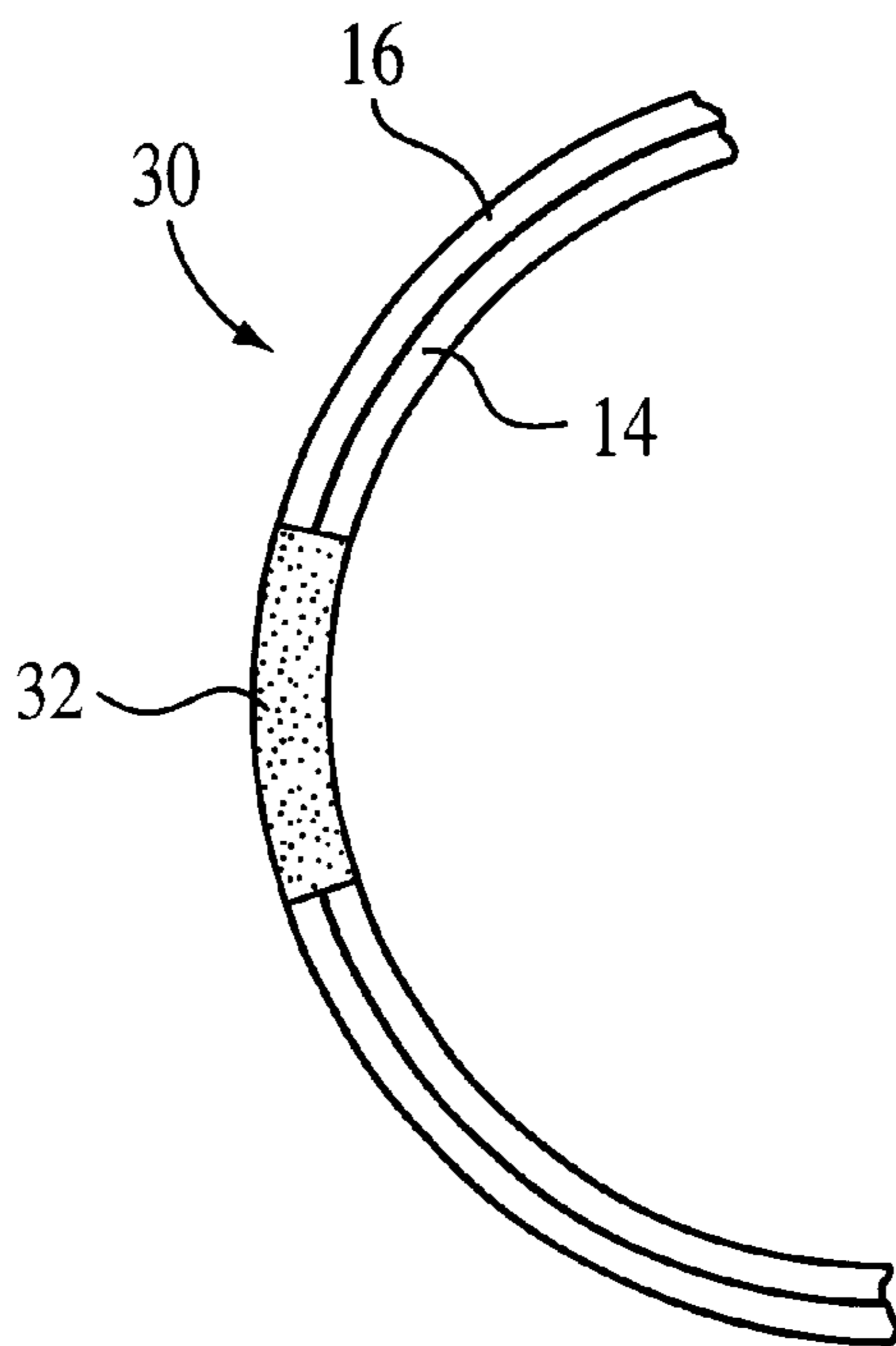


FIG. 6

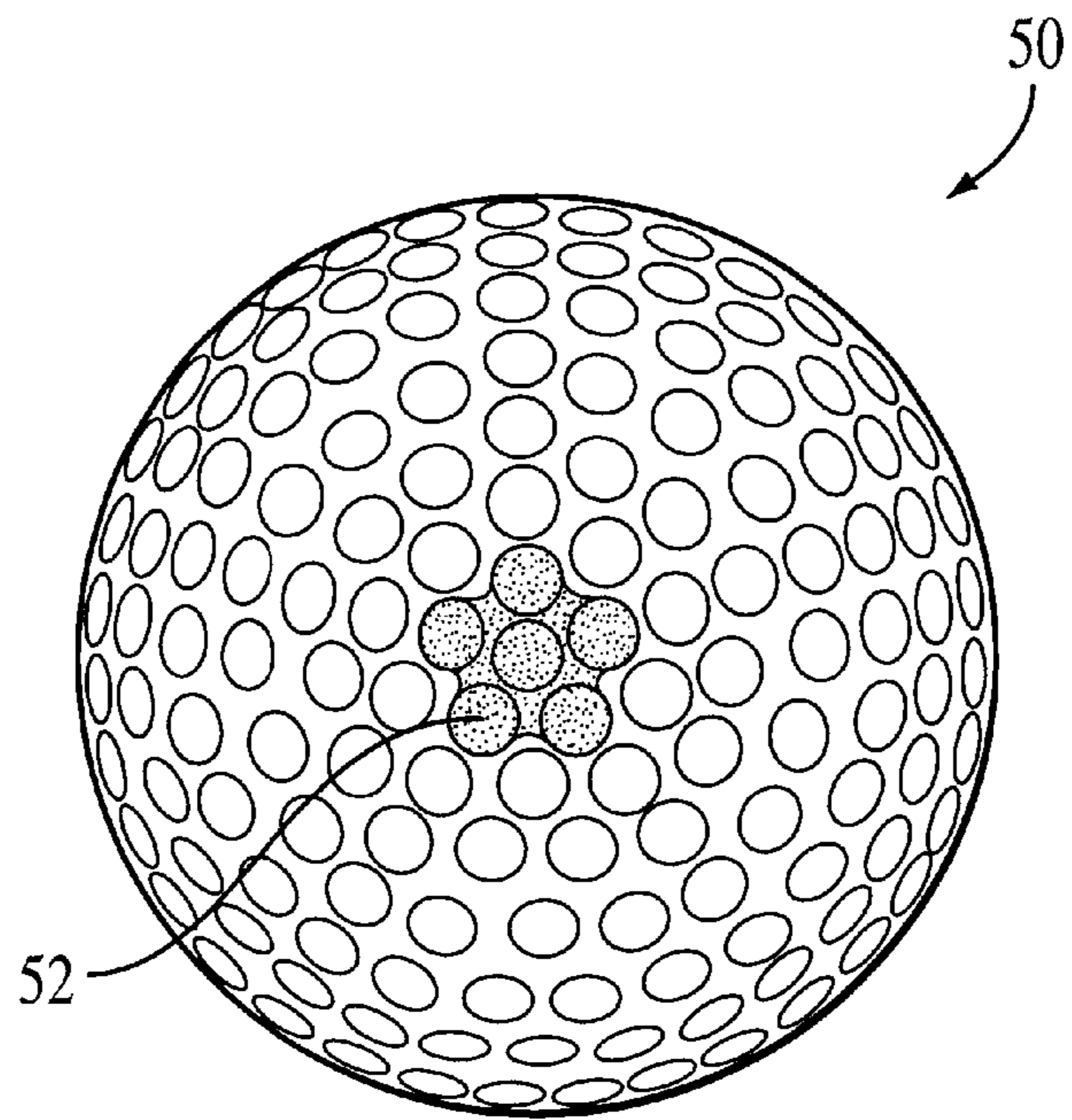


FIG. 7

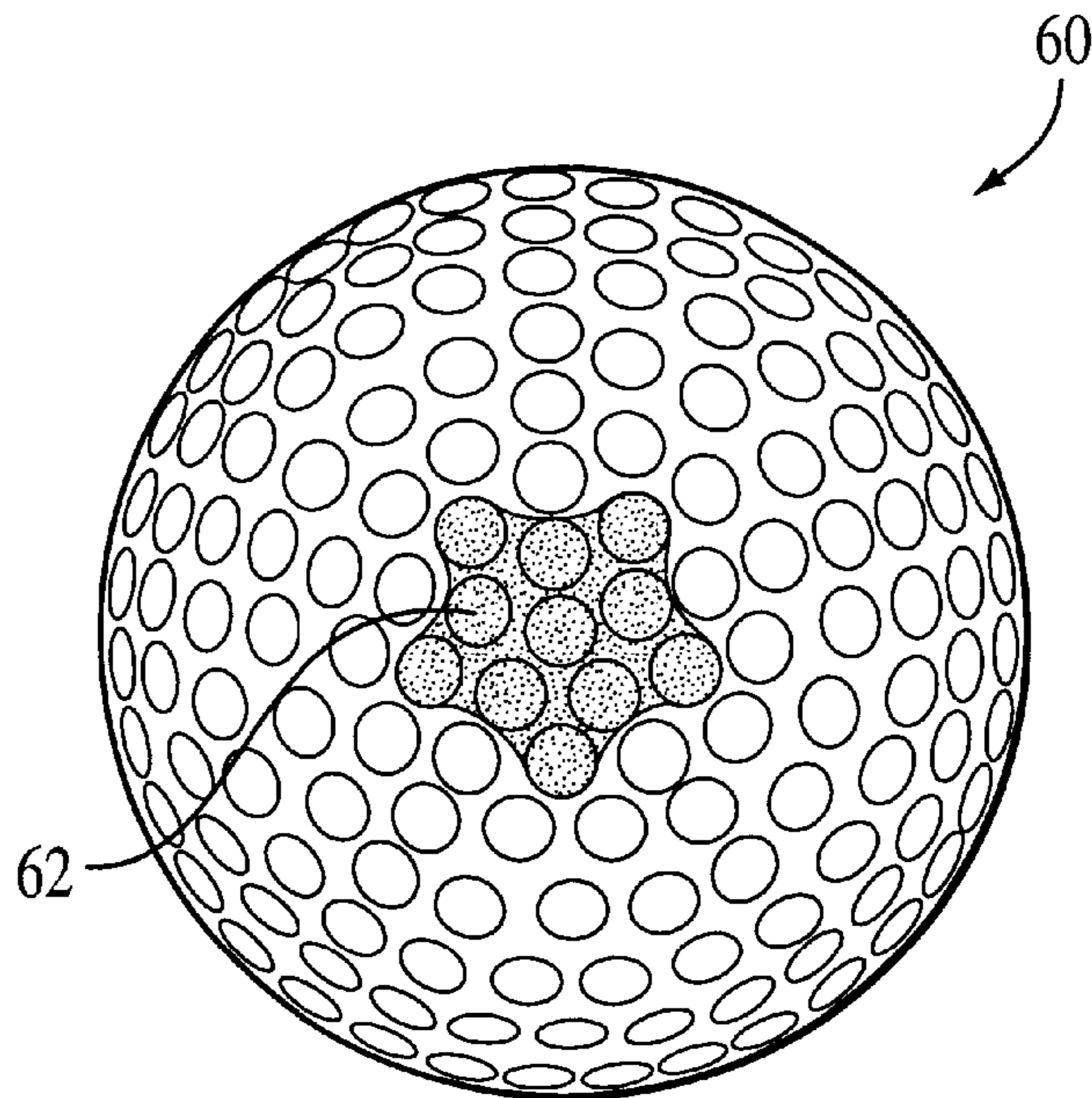


FIG. 8

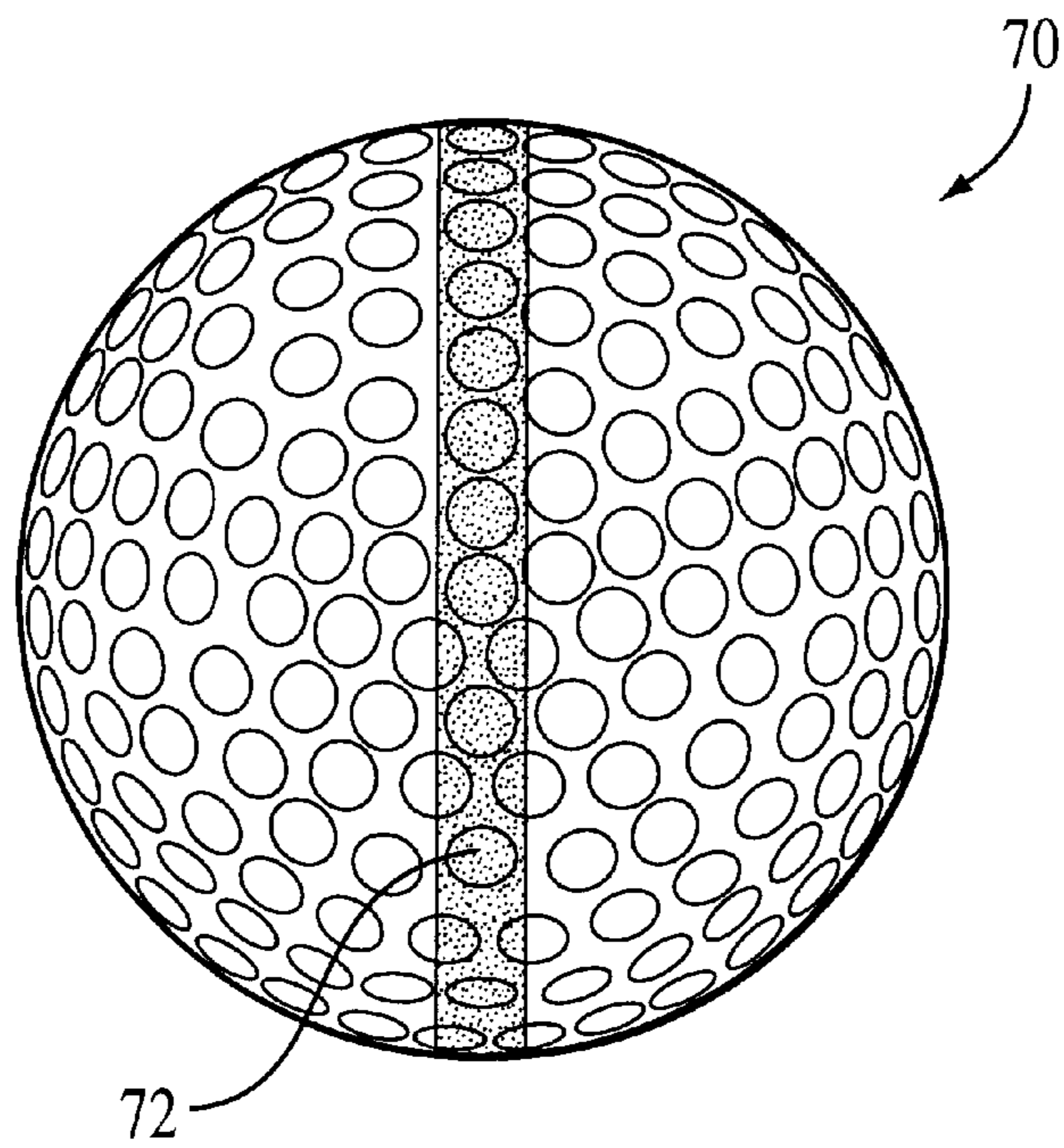


FIG. 9

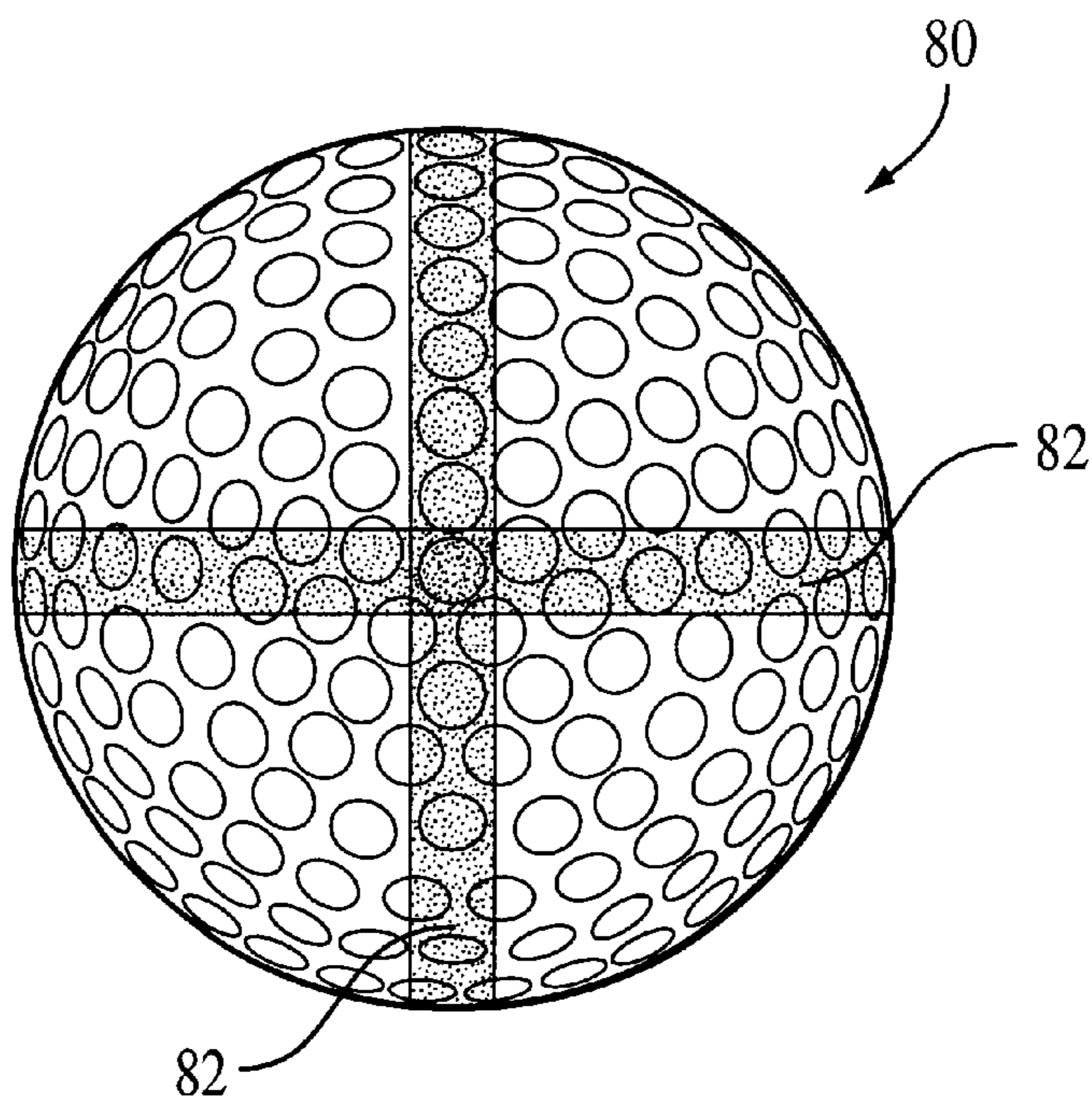


FIG. 10

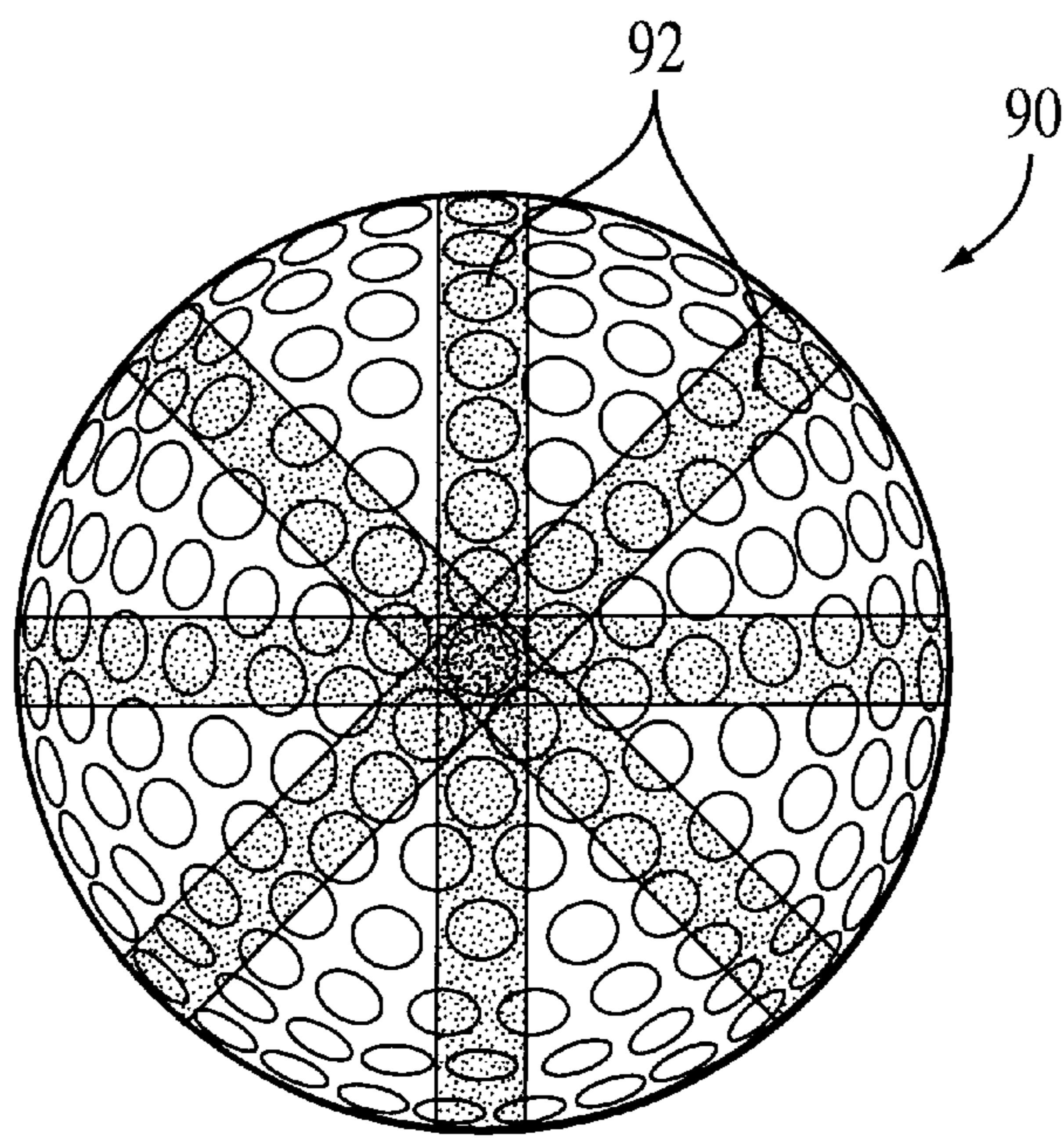


FIG. 11

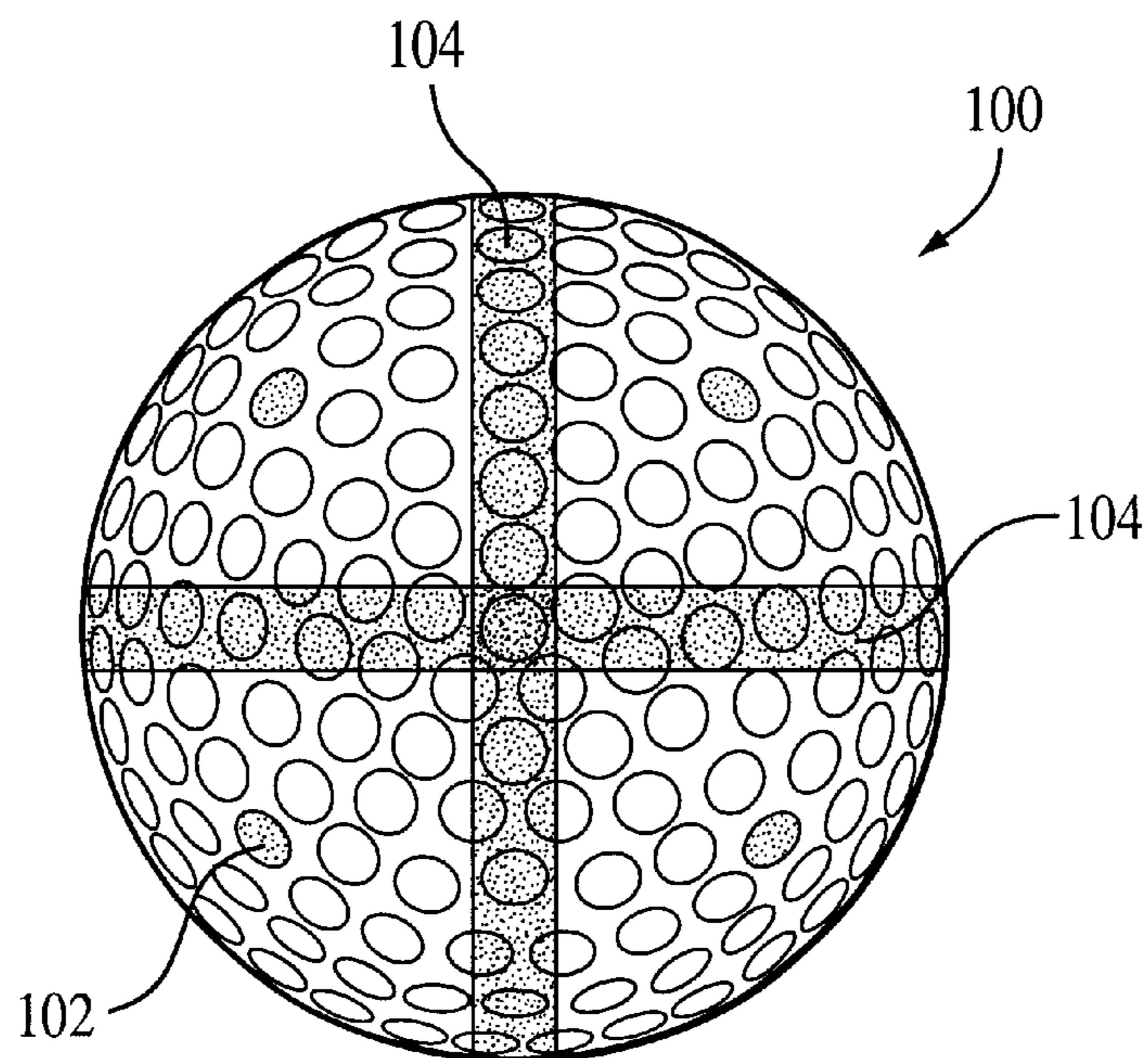


FIG. 12



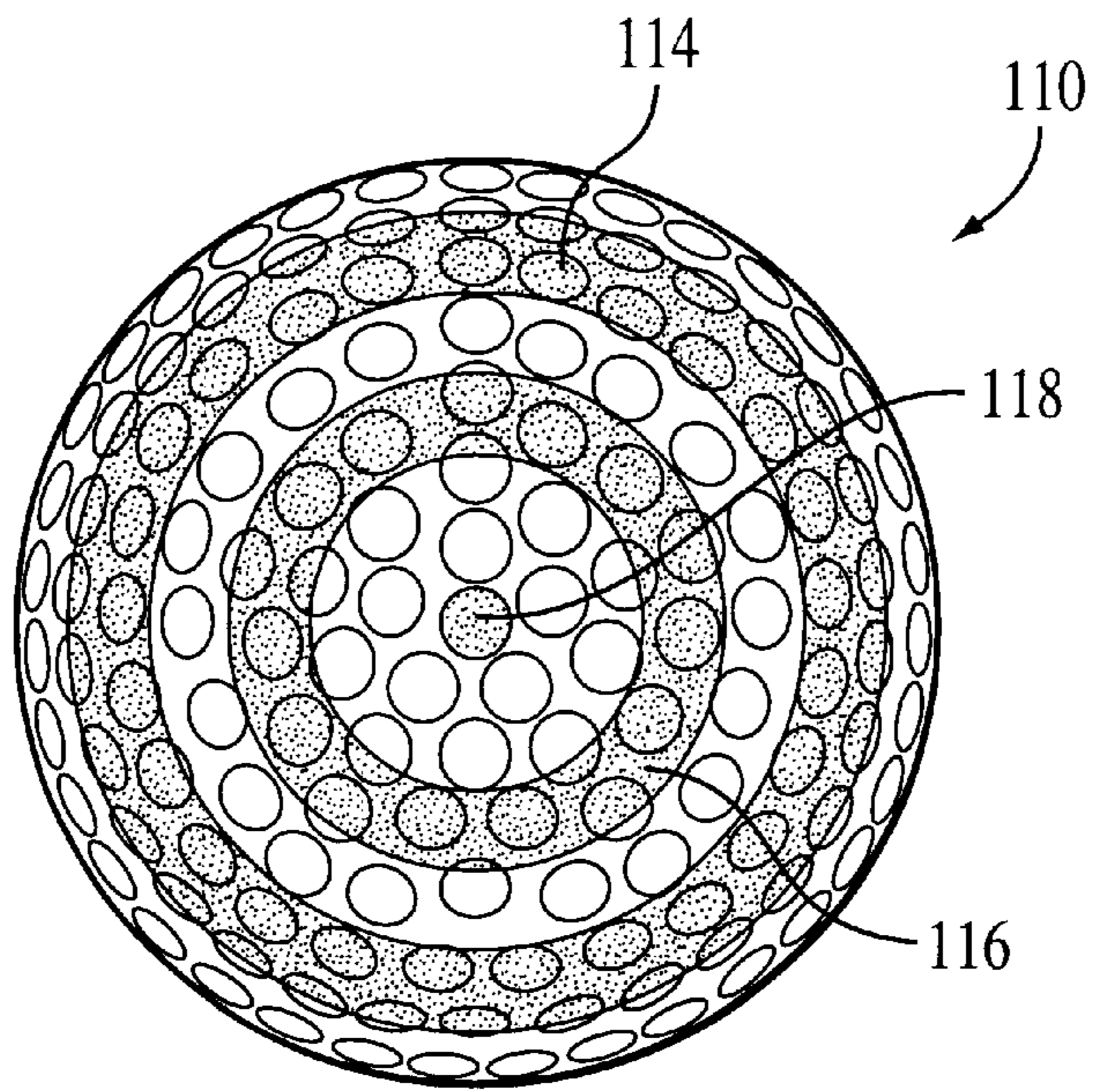


FIG. 13

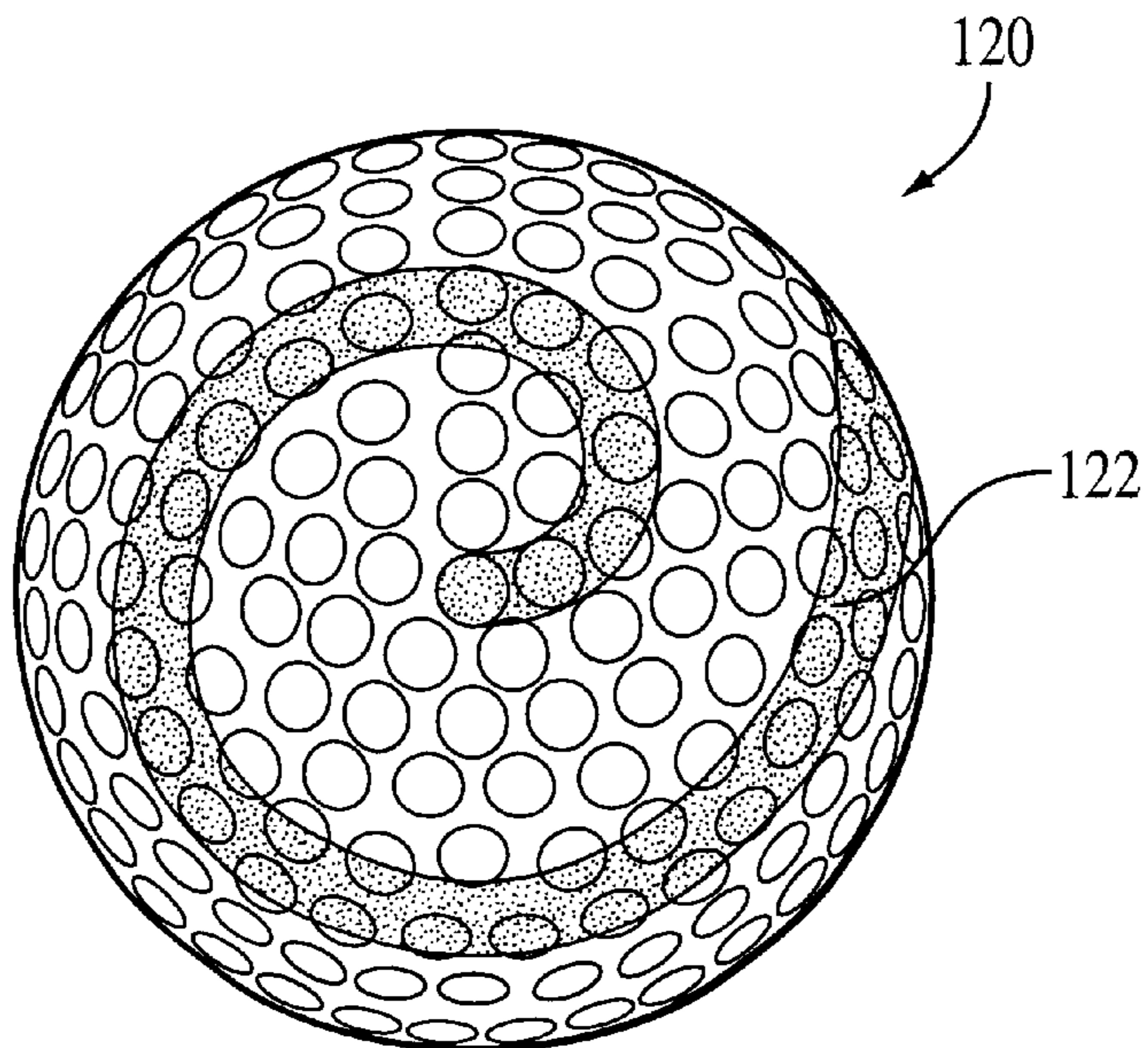


FIG. 14

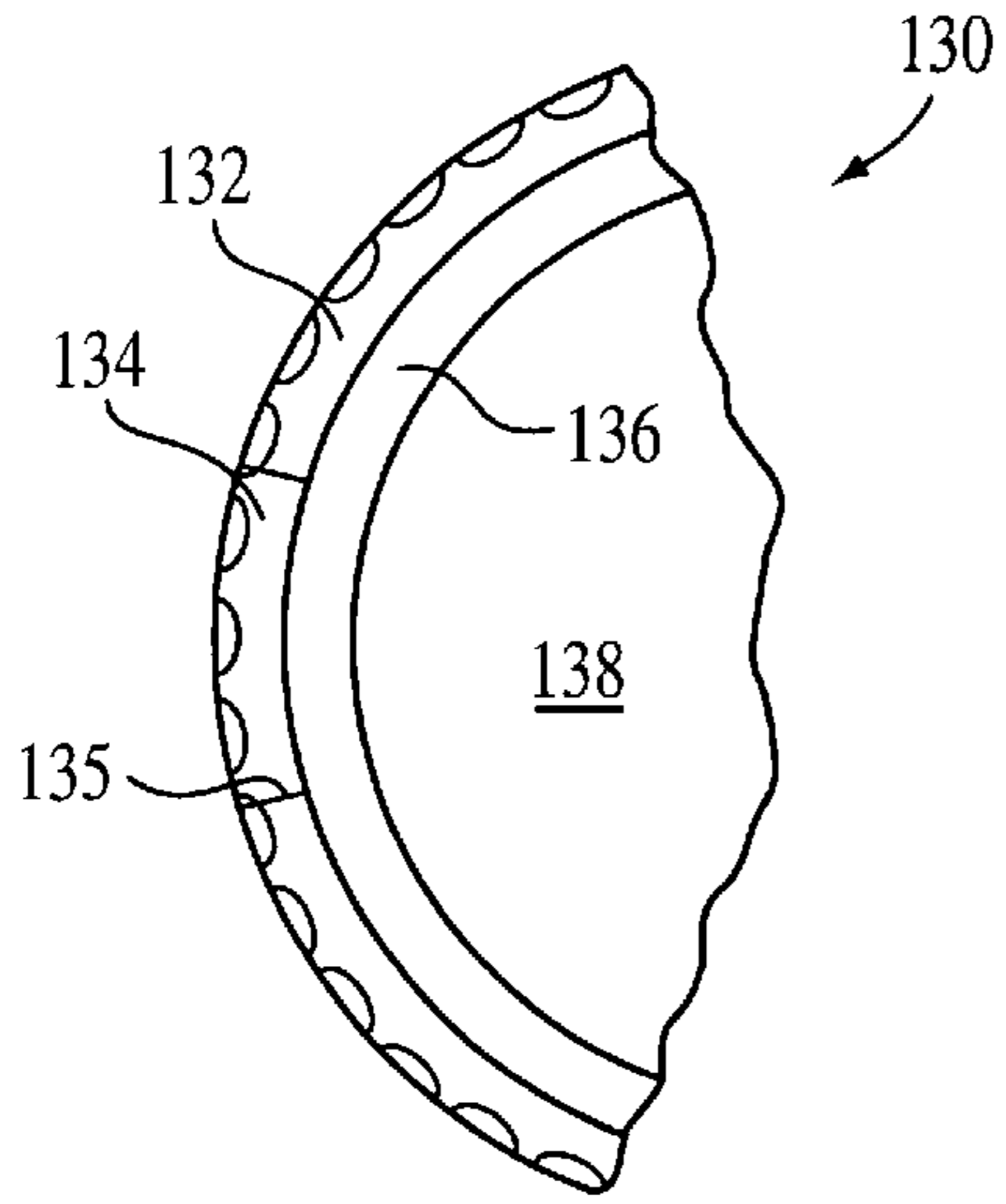


FIG. 15

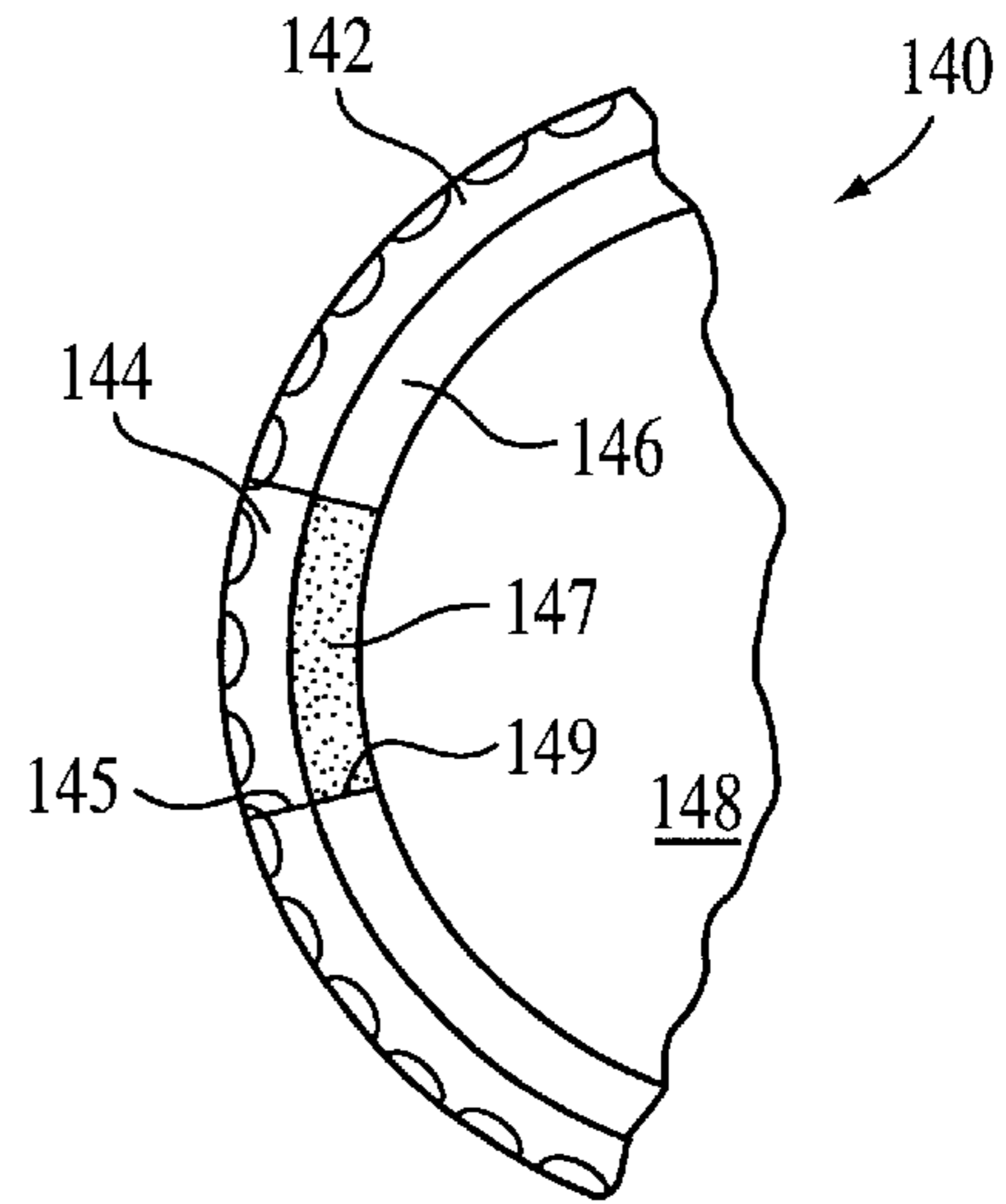


FIG. 16

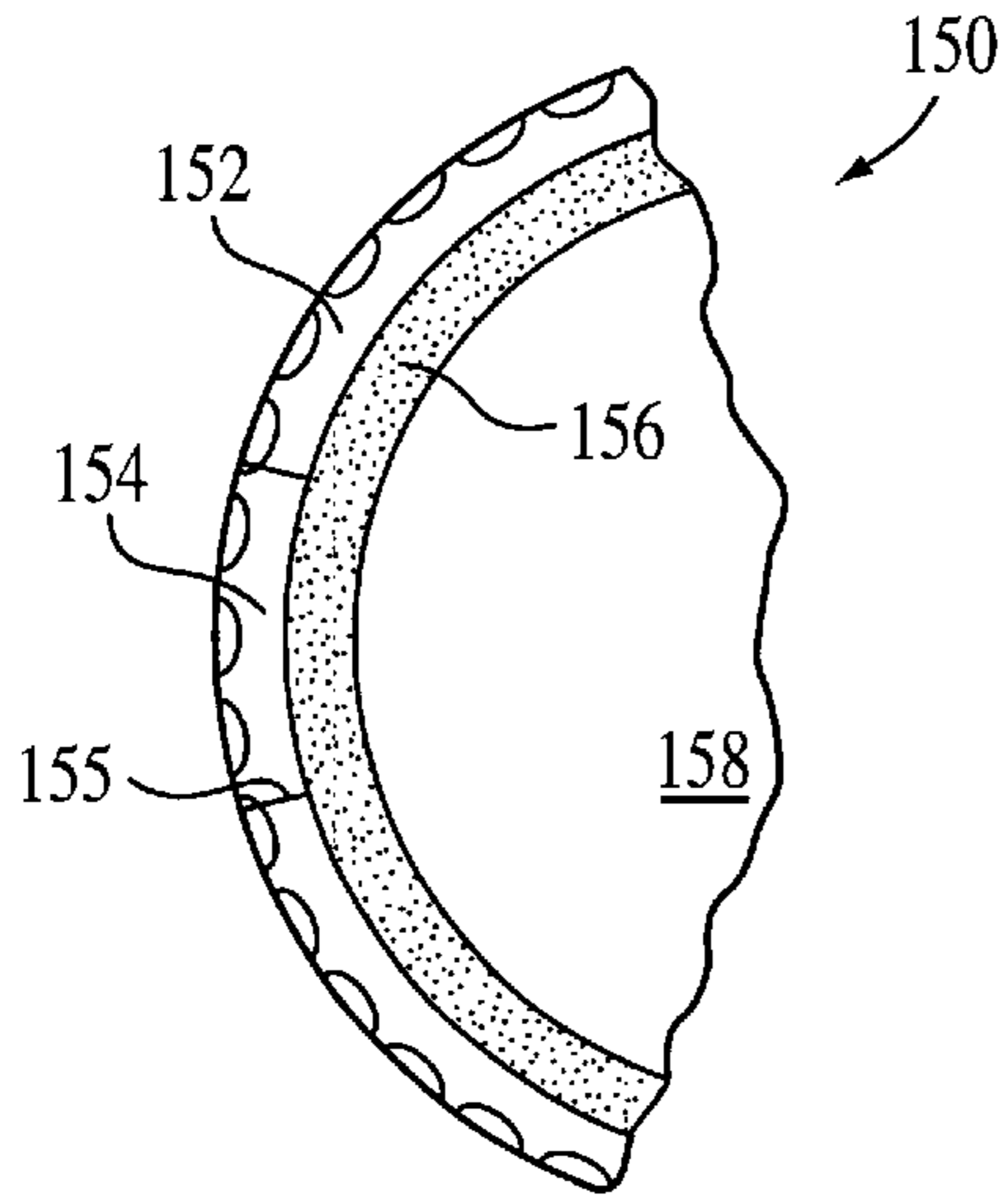


FIG. 17

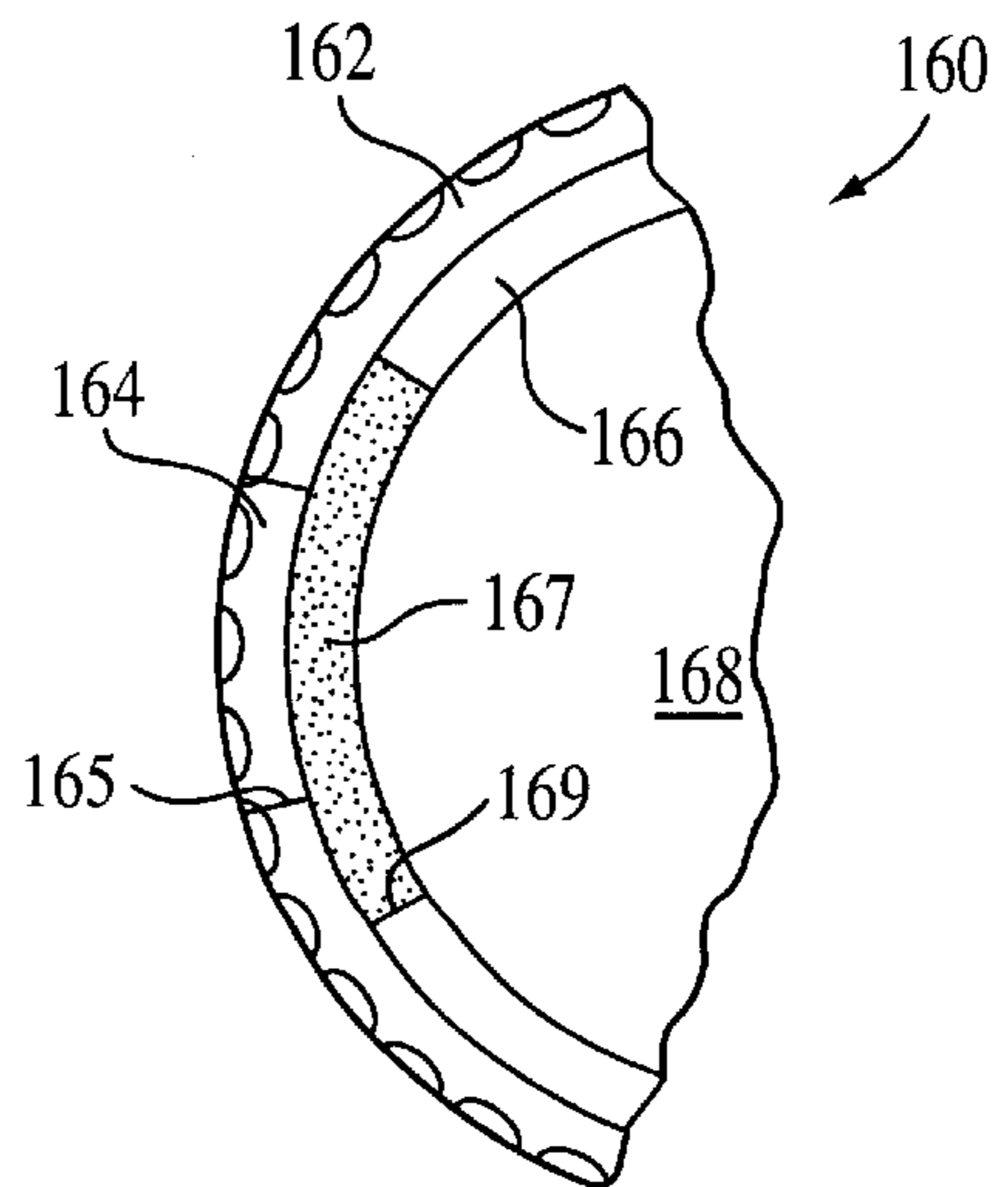


FIG. 18

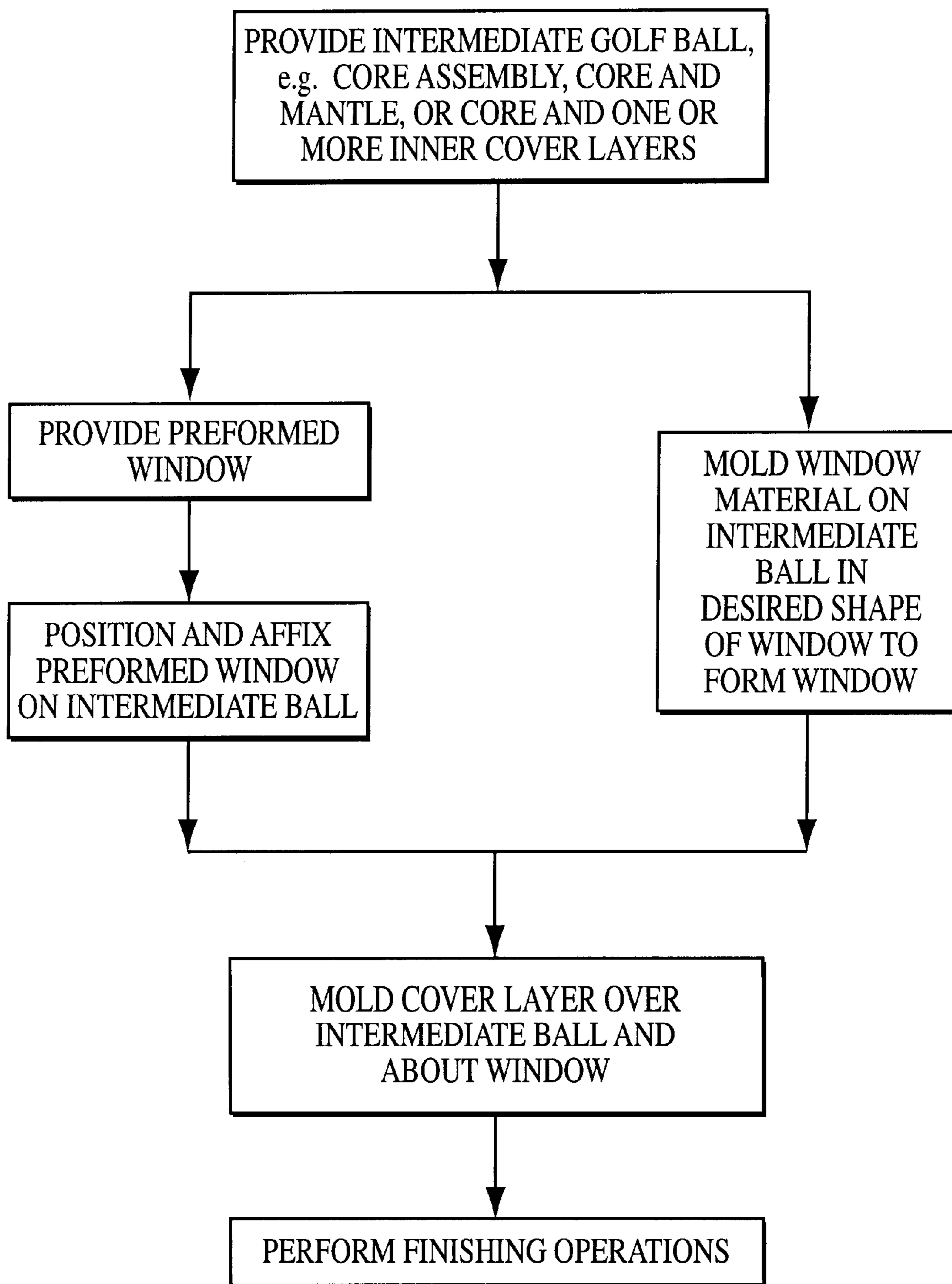


FIG. 19

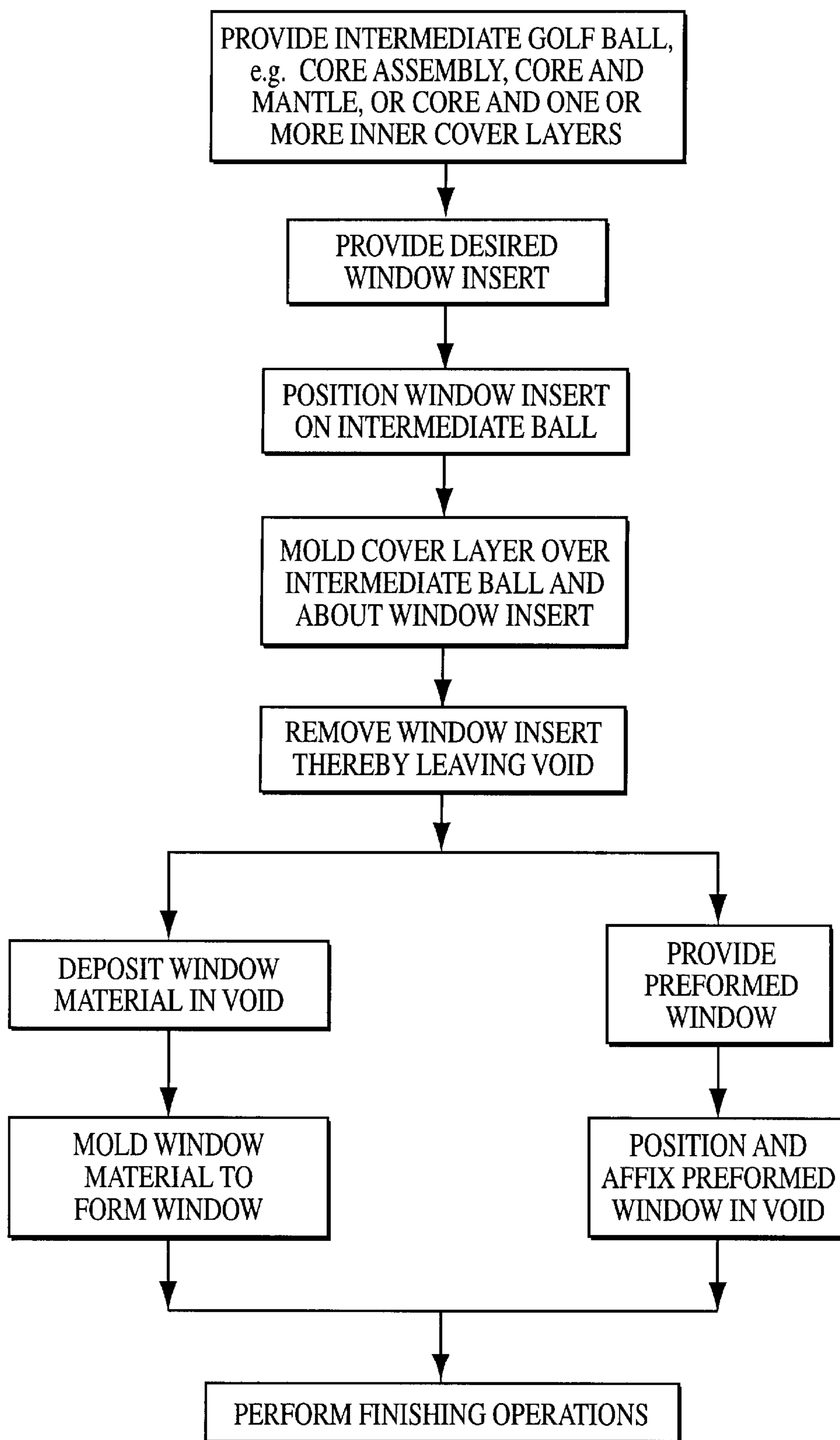


FIG. 20

## PERIMETER WEIGHTED GOLF BALL WITH VISIBLE WEIGHTING

### CROSS-REFERENCE TO RELATED APPLICATIONS

The present application claims priority from U.S. Provisional Application Ser. No. 60/042,428 filed Mar. 28, 1997, and is a continuation-in-part from U.S. application Ser. No. 08/782,221, filed Jan. 13, 1997, now U.S. Pat. No. 6,015,356. The present application is also a continuation-in-part from U.S. applications Ser. No. 09/049,868 filed Mar. 27, 1998, now U.S. Pat. No. 5,984,806.

### FIELD OF THE INVENTION

The present invention pertains to the construction of regulation golf balls including golf balls having enhanced distance and feel characteristics. More particularly, the invention relates to improved multi-layer golf balls having one or more layers containing metal particles or other heavy weight filler materials to enhance the perimeter weight of the balls. Such weighting material may be incorporated in one or more of an inner layer or an outer layer. Preferably, the heavy weight filler particles are present in an outer cover layer. Most preferably, the weighting material is visible along the exterior of the ball. The inclusion of the particles along with the production of a smaller core produces a greater (or higher) moment of inertia. This results in less spin, reduced slicing and hooking and further distance. Additionally, the golf balls of the invention have essentially the same "feel" characteristic of softer balata covered balls.

### BACKGROUND OF THE INVENTION

Golf balls utilized in tournament or competitive play today are regulated for consistency purposes by the United States Golf Association (U.S.G.A.). In this regard, there are five (5) U.S.G.A. specifications which golf balls must meet under controlled conditions. These are size, weight, velocity, driver distance and symmetry.

Under the U.S.G.A. specifications, a golf ball can not weigh more than 1.62 ounces (with no lower limit) and must measure at least 1.68 inches (with no upper limit) in diameter. However, as a result of the openness of the upper or lower parameters in size and weight, a variety of golf balls can be made. For example, golf balls are manufactured today which by the Applicant are slightly larger (i.e., approximately 1.72 inches in diameter) while meeting the weight, velocity, distance and symmetry specifications set by the U.S.G.A.

Additionally, according to the U.S.G.A., the initial velocity of the ball must not exceed 250 ft/sec. with a 2% maximum tolerance (i.e., 255 ft/sec.) when struck at a set club head speed on a U.S.G.A. machine. Furthermore, the overall distance of the ball must not exceed 280 yards with a 6% tolerance (296.8 yards) when hit with a U.S.G.A. specified driver at 160 ft/sec. (clubhead speed) at a 10 degree launch angle as tested by the U.S.G.A. Lastly, the ball must pass the U.S.G.A. administered symmetry test, i.e., fly consistency (in distance, trajectory and time of flight) regardless of how the ball is placed on the tee.

While the U.S.G.A. regulates five (5) specifications for the purposes of maintaining golf ball consistency, alternative characteristics (i.e., spin, feel, durability, distance, sound, visibility, etc.) of the ball are constantly being improved upon by golf ball manufacturers. This is accomplished by altering the type of materials utilized and/or improving

construction of the balls. For example, the proper choice of cover and core materials are important in achieving certain distance, durability and playability properties. Other important factors controlling golf ball performance include, but are not limited to, cover thickness and hardness, core stiffness (typically measured as compression), ball size and surface configuration.

As a result, a wide variety of golf balls have been designed and are available to suit an individual player's game. Moreover, improved golf balls are continually being produced by golf ball manufacturers with technologized advancements in materials and manufacturing processes.

Two of the principal properties involved in a golf ball's performance are resilience and compression. Resilience is generally defined as the ability of a strained body, by virtue of high yield strength and low elastic modulus, to recover its size and form following deformation. Simply stated, resilience is a measure of energy retained to the energy lost when the ball is impacted with the club.

In the field of golf ball production, resilience is determined by the coefficient of restitution (C.O.R.), the constant "e" which is the ratio of the relative velocity of an elastic sphere after direct impact to that before impact. As a result, the coefficient of restitution ("e") can vary from 0 to 1, with 1 being equivalent to a perfectly or completely elastic collision and 0 being equivalent to a perfectly or completely inelastic collision.

Resilience (C.O.R.), along with additional factors such as club head speed, club head mass, angle of trajectory, ball size, density, composition and surface configuration (i.e., dimple pattern and area of coverage) as well as environmental conditions (i.e., temperature, moisture, atmospheric pressure, wind, etc.) generally determine the distance a golf ball will travel when hit. Along this line, the distance a golf ball will travel under controlled environmental conditions is a function of the speed and mass of the club and the size, density, composition and resilience (C.O.R.) of the ball and other factors. The initial velocity of the club, the mass of the club and the angle of the ball's departure are essentially provided by the golfer upon striking. Since club head, club head mass, the angle of trajectory and environmental conditions are not determinants controllable by golf ball producers and the ball size and weight are set by the U.S.G.A., these are not factors of concern among golf ball manufacturers. The factors or determinants of interest with respect to improved distance are generally the coefficient of restitution (C.O.R.), spin and the surface configuration (dimple pattern, ratio of land area to dimple area, etc.) of the ball.

The coefficient of restitution (C.O.R.) in solid core balls is a function of the composition of the molded core and of the cover. The molded core and/or cover may be comprised of one or more layers such as in multi-layered balls. In balls containing a wound core (i.e., balls comprising a liquid or solid center, elastic windings, and a cover), the coefficient of restitution is a function of not only the composition of the center and cover, but also the composition and tension of the elastomeric windings. As in the solid core balls, center and cover of a wound core ball may also consist of one or more layers.

The coefficient of restitution of a golf ball can be analyzed by determining the ratio of the outgoing velocity to the incoming velocity. In the examples of this writing, the coefficient of restitution of a golf ball was measured by propelling a ball horizontally at a speed of 125+/-1 feet per second (fps) against a generally vertical, hard, flat steel plate and measuring the ball's incoming and outgoing velocity

electronically. Speeds were measured with a pair of Oehler Mark 55 ballistic screens (available from Oehler Research Austin Tex.), which provide a timing pulse when an object passes through them. The screens are separated by 36" and are located 25.25" and 61.25" from the rebound wall. The ball speed was measured by timing the pulses from screen 1 to screen 2 on the way into the rebound wall (as the average speed of the ball over 36"), and then the exit speed was timed from screen 2 to screen 1 over the same distance. The rebound wall was tilted 2 degrees from a vertical plane to allow the ball to rebound slightly downward in order to miss the edge of the cannon that fired it.

As indicated above, the incoming speed should be 125+/-1 fps. Furthermore, the correlation between C.O.R. and forward or incoming speed has been studied and a correction has been made over the +/- fps range so that the C.O.R. is reported as if the ball had an incoming speed of exactly 125.0 fps.

The coefficient of restitution must be carefully controlled in all commercial golf balls if the ball is to be within the specifications regulated by the U.S.G.A. As mentioned to some degree above, the U.S.G.A. standards indicate that a "regulation" ball cannot have an initial velocity exceeding 255 feet per second in an atmosphere of 75° F. when tested on a U.S.G.A. machine. Since the coefficient of restitution of a ball is related to the ball's initial velocity, it is highly desirable to produce a ball having sufficiently high coefficient of restitution (C.O.R.) to closely approach the U.S.G.A. limit on initial velocity, while having an ample amount of softness (i.e., hardness) to produce the desired degree of playability (i.e., spin, etc.).

Furthermore, the maximum distance a golf ball can travel (carry and roll) when tested on a U.S.G.A. driving machine set at a club head speed of 160 feet/second is 296.8 yards. While golf ball manufacturers design golf balls which closely approach this driver distance specification, there is no upper limit for how far an individual player can drive a ball. Thus, while golf ball manufacturers produced balls having certain resilience characteristics in order to approach the maximum distance parameter set by the U.S.G.A. under controlled conditions, the overall distance produced by a ball in actual play will vary depending on the specific abilities of the individual golfer.

The surface configuration of a ball is also an important variable in affecting a ball's travel distance. The size and shape of the ball's dimples, as well as the overall dimple pattern and ratio of land area to dimpled area are important with respect to the ball's overall carrying distance. In this regard, the dimples provide the lift and decrease the drag for sustaining the ball's initial velocity in flight as long as possible. This is done by displacing the air (i.e., displacing the air resistance produced by the ball from the front of the ball to the rear) in a uniform manner. The shape, size, depth and pattern of the dimple affect the ability to sustain a ball's initial velocity differently.

As indicated above, compression is another property involved in the overall performance of a golf ball. The compression of a ball will influence the sound or "click" produced when the ball is properly hit. Similarly, compression can affect the "feel" of the ball (i.e., hard or soft responsive feel), particularly in chipping and putting.

Moreover, while compression of itself has little bearing on the distance performance of a ball, compression can affect the playability of the ball on striking. The degree of compression of a ball against the club face and the softness of the cover strongly influences the resultant spin rate.

Typically, a softer cover will produce a higher spin rate than a harder cover. Additionally, a harder core will produce a higher spin rate than a softer core. This is because at impact a hard core serves to compress the cover of the ball against the face of the club to a much greater degree than a soft core thereby resulting in more "grab" of the ball on the clubface and subsequent higher spin rates. In effect the cover is squeezed between the relatively incompressible core and clubhead. When a softer core is used, the cover is under much less compressive stress than when a harder core is used and therefore does not contact the clubface as intimately. This results in lower spin rates.

The term "compression" utilized in the golf ball trade generally defines the overall deflection that a golf ball undergoes when subjected to a compressive load. For example, PGA compression indicates the amount of change in a golf ball's shape upon striking. The development of solid core technology in two-piece balls has allowed for much more precise control of compression in comparison to thread wound three-piece balls. This is because in the manufacture of solid core balls, the amount of deflection or deformation is precisely controlled by the chemical formula used in making the cores. This differs from wound three-piece balls wherein compression is controlled in part by the winding process of the elastic thread. Thus, two-piece and multilayer solid core balls exhibit much more consistent compression readings than balls having wound cores such as the thread wound three-piece balls.

Additionally, cover hardness and thickness are important in producing the distance, playability and durability properties of a golf ball. As mentioned above, cover hardness directly affects the resilience and thus distance characteristics of a ball. All things being equal, harder covers produce higher resilience. This is because soft materials detract from resilience by absorbing some of the impact energy as the material is compressed on striking.

Furthermore, soft covered balls are preferred by the more skilled golfer because he or she can impact high spin rates that give him or her better control or workability of the ball. Spin rate is an important golf ball characteristic for both the skilled and unskilled golfer. As just mentioned, high spin rates allow for the more skilled golfer, such as PGA and LPGA professionals and low handicap players, to maximize control of the golf ball. This is particularly beneficial to the more skilled golfer when hitting an approach shot to a green. The ability to intentionally produce "back spin", thereby stopping the ball quickly on the green, and/or "side spin" to draw or fade the ball, substantially improves the golfer's control over the ball. Thus, the more skilled golfer generally prefers a golf ball exhibiting high spin rate properties.

However, a high spin golf ball is not desirable by all golfers, particularly high handicap players who cannot intentionally control the spin of the ball. Additionally, since a high spinning ball will roll substantially less than a low spinning golf ball, a high spinning ball is generally short on distance.

In this regard, less skilled golfers, have, among others, two substantial obstacles to improving their game: slicing and hooking. When a club head meets a ball, an unintentional side spin is often imparted which sends the ball off its intended course. The side spin reduces one's control over the ball as well as the distance the ball will travel. As a result, unwanted strokes are added to the game.

Consequently, while the more skilled golfer frequently desires a high spin golf ball, a more efficient ball for the less skilled player is a golf ball that exhibits low spin properties.

The low spin ball reduces slicing and hooking and enhances distance. Furthermore, since a high spinning ball is generally short on distance, such a ball is not universally desired by even the more skilled golfer.

With respect to high spinning balls, up to approximately twenty years ago, most high spinning balls were comprised of balata or blends of balata with elastomeric or plastic materials. The traditional balata covers are relatively soft and flexible. Upon impact, the soft balata covers compress against the surface of the club producing high spin. Consequently, the soft and flexible balata covers provide an experienced golfer with the ability to apply a spin to control the ball in flight in order to produce a draw or a fade, or a backspin which causes the ball to "bite" or stop abruptly on contact with the green.

Moreover, the soft balata covers produce a soft "feel" to the low handicap player. Such playability properties (workability, feel, etc.) are particularly important in short iron play with low swing speeds and are exploited significantly by relatively skilled players.

However, despite all the benefits of balata, balata covered golf balls are easily cut and/or damaged if mis-hit. Golf balls produced with balata or balata-containing cover compositions therefore have a relatively short lifespan.

Additionally, soft balata covered balls are shorter in distance. While the softer materials will produce additional spin, this is frequently produced at the expense of the initial velocity of the ball. Moreover, as mentioned above, higher spinning balls tend to roll less.

As a result of these negative properties, balata and its synthetic substitutes, transpolyisoprene and transpolybutadiene, have been essentially replaced as the cover materials of choice by new synthetic materials. Included in this group of materials are ionomer resins.

Ionomeric resins are polymers in which the molecular chains are cross-linked by ionic bonds. As a result of their toughness, durability and flight characteristics, various ionomeric resins sold by E. I. DuPont de Nemours & Company under the trademark "Surlyn®" and more recently, by the Exxon Corporation (see U.S. Pat. No. 4,911,451) under the trademarks "Escor®" and the trade name "Iotek", have become the materials of choice for the construction of golf ball covers over the traditional "balata" (transpolyisoprene, natural or synthetic) rubbers. As stated, the softer balata covers, although exhibiting enhanced playability properties, lack the durability (cut and abrasion resistance, fatigue endurance, etc.) properties required for repetitive play and are limited in distance.

Ionomeric resins are generally ionic copolymers of an olefin, such as ethylene, and a metal salt of an unsaturated carboxylic acid, such as acrylic acid, methacrylic acid, or maleic acid. Metal ions, such as sodium or zinc, are used to neutralize some portion of the acidic group in the copolymer resulting in a thermoplastic elastomer exhibiting enhanced properties, i.e. durability, etc., for golf ball cover construction over balata.

Historically, some of the advantages produced by ionomer resins gained in increased durability were offset to some degree by decreases produced in playability. This was because although the ionomeric resins were very durable, they initially tended to be very hard when utilized for golf ball cover construction, and thus lacked the degree of softness required to impart the spin necessary to control the ball in flight. Since the initial ionomeric resins were harder than balata, the ionomeric resin covers did not compress as much against the face of the club upon impact, thereby producing less spin.

In addition, the initial, harder and more durable ionomeric resins lacked the "feel" characteristic associated with the softer balata related covers. The ionomer resins tended to produce a hard responsive "feel" when struck with a golf club such as a wood, iron, wedge or putter.

As a result of these difficulties and others, a great deal of research has been and is currently being conducted by golf ball manufacturers in the field of ionomer resin technology. There are currently more than fifty (50) commercial grades of ionomers available both from DuPont and Exxon, with a wide range of properties which vary according to the type and amount of metal cations, molecular weight, composition of the base resin (i.e., relative content of ethylene and methacrylic and/or acrylic acid groups) and additive ingredients such as reinforcement agents, etc. However, a great deal of research continues in order to develop golf ball cover compositions exhibiting not only the improved impact resistance and carrying distance properties produced by the "hard" ionomeric resins, but also the playability (i.e., "spin", "feel", etc.) characteristics previously associated with the "soft" balata covers, properties which are still desired by the more skilled golfer.

Consequently, a number of two-piece (a solid resilient center or core with a molded cover) and three-piece (a liquid or solid center, elastomeric winding about the center, and a molded cover) golf balls have been produced by the Applicant and others to address these needs. The different types of materials utilized to formulate the cores, covers, etc. of these balls dramatically alters the balls' overall characteristics.

In addition, multi-layered covers containing one or more ionomer resins have also been formulated in an attempt to produce a golf ball having the overall distance, playability and durability characteristics desired. For example, this was addressed by Spalding Sports Worldwide, Inc., the assignee of the present invention, in U.S. Pat. No. 4,431,193 where the construction of a multi-layered golf ball having two ionomer resin cover layers is disclosed.

In the examples of the '193 patent, a multi-layer golf ball is produced by initially molding a first cover layer on a solid spherical core and then adding a second layer. The first layer is comprised of a hard, high flexural modulus resinous material such as type 1605 Surlyn® (now designated Surlyn® 8940). Type 1605 Surlyn® (Surlyn® 8940) is a sodium ion based low acid (less than or equal to 15 weight percent methacrylic acid) ionomer resin having a flexural modulus of about 51,000 psi. An outer layer of a comparatively soft, low flexural modulus resinous material such as type 1855 Surlyn® (now designated Surlyn® 9020) is molded over the inner cover layer. Type 1855 Surlyn® (Surlyn® 9020) is a zinc ion based low acid (10 weight percent methacrylic acid) ionomer resin having a flexural modulus of about 14,000 psi.

The '193 patent teaches that the hard, high flexural modulus resin which comprises the first layer provides for a gain in coefficient of restitution over the coefficient of restitution of the core. The increase in the coefficient of restitution provides a ball which serves to attain or approach the maximum initial velocity limit of 255 feet per second as provided by the United States Golf Association (U.S.G.A.) rules. The relatively soft, low flexural modulus outer layer provides essentially no gain in the coefficient of restitution but provides for the advantageous "feel" and playing characteristics of a balata covered golf ball.

Unfortunately, however, while the ball of the examples of the '193 patent do exhibit enhanced playability characteristics with improved distance (i.e. enhanced C.O.R. values) over a number of other then known multi-layered balls, the

balls suffer from relatively short distance (i.e. lower C.O.R. values) when compared to two-piece, single cover layer balls commercially available today. These undesirable properties make the balls produced in accordance with the limited examples of the '193 patent generally unacceptable by today's standards.

The present invention is directed to new multi-layer golf ball compositions which provide for enhanced coefficient of restitution (i.e, improved travel distance) and/or durability properties when compared to the multi-layer balls found in the examples of the prior art. The travel distance of the balls of the invention is further improved by increasing the balls' moment of inertia and thereby reducing their overall spin rate.

Moreover, the balls of the invention have enhanced outer cover layer softness and feel. The improvements in distance, feel, etc. are produced without substantial sacrifices in controllability resulting from the loss of spin produced by the balls' increased moment of inertia.

As previously noted, a low spin ball is generally preferred, particularly for the less skilled player. And, as noted, increasing the moment of inertia of the ball tends to reduce the spin rate of the ball. The present invention provides a remarkable and unique approach for readily increasing the moment of inertia of a golf ball. The approach of the present invention is economical and easily implemented in large scale commercial golf ball manufacturing processes.

These and other objects and features of the invention will be apparent from the following summary of the invention, description of the preferred embodiments, the drawings and from the claims.

#### SUMMARY OF THE INVENTION

The present invention provides, in a first aspect, a golf ball comprising a golf ball comprising a core and a cover assembly disposed about the core. The cover assembly includes a recessed region along the outer surface of the ball in which is located a viewing window to allow the material under the viewing window to be seen from the exterior of the golf ball.

In yet another aspect, the present invention provides a golf ball comprising a core, a first cover layer disposed about the core, a second cover layer disposed about the first cover layer which also provides a recessed region along the outer surface of the ball and a viewing window disposed in that recessed region. The first cover layer includes a particulate weighting material. The viewing window which is disposed in the recessed region is generally transparent and enables at least a portion of the particulate weighting material in the first cover layer to be seen from the outer surface of the ball.

In a further aspect of the present invention, a golf ball comprising a core, a first cover layer, and a second cover layer is provided. The first cover layer disposed about the core, includes particulate weighting material. The second cover layer which is disposed on the first cover layer and which generally provides an outer dimpled surface of the golf ball, has a first generally opaque portion and a second generally transparent portion. The configuration of the golf ball is such that the particulate weighting material in the first cover layer is visible through the second generally transparent portion of the second cover layer.

The present invention also provides methods for forming golf balls having viewing windows as described herein. In a first aspect, the present invention provides a method of producing a golf ball having a viewing window along the

outer surface of the golf ball in which the method includes the following steps. An intermediate golf ball component is provided along with a preformed window component. A step of positioning and affixing the preformed window component on the intermediate golf ball component is preformed. Next a cover layer is formed over the intermediate golf ball component and generally about the window component.

In accordance with another aspect of the present invention, a method is provided for producing a golf ball having a viewing window in which an intermediate golf ball component is first provided. Next, a viewing window is molded on the intermediate golf ball component. Next, a step of forming a cover layer over the intermediate golf ball component and generally about the viewing window is performed to thereby produce the noted golf ball having a viewing window.

In another aspect of the present invention, a method is provided for forming such golf balls in which an intermediate golf ball component is provided, a window insert is provided, and the window insert is then positioned on the intermediate golf ball component. Next, a cover layer is formed over the intermediate golf ball component and generally about the window insert. The window insert is then removed thereby leaving a void or recessed region within the cover layer. Next, window material is deposited in the void. And, the window material is then molded within the void to thereby form the viewing window. Accordingly, a golf ball having a viewing window along its outer surface is thus formed.

In another aspect according to the present invention, a method for producing such golf balls involves providing an intermediate golf ball component and providing a window insert. The window insert is then positioned on the intermediate golf ball component. A cover layer is then formed over the intermediate golf ball component and about the window insert. The window insert is then removed thereby leaving a void or recessed region within the cover layer. Next, a preformed viewing window is provided and positioned and affixed within the void to thereby produce the golf ball having a viewing window along its outer surface.

These and other objects and features of the invention will be apparent from the following detailed description.

#### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a cross-sectional view of a preferred embodiment golf ball embodying the invention illustrating a core 10 and a multi-layer cover 12 consisting of an inner layer 14 containing metal particles or other heavy filler materials 20 and an outer layer 16 having dimples 18;

FIG. 2 is a diametrical cross-sectional view of a preferred embodiment golf ball of the invention having a core 10 and a cover 12 made of an inner layer 14 containing metal particles or other fragments 20 and an outer layer 16 having dimple 18;

FIG. 3 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible star-shaped perimeter weighting system;

FIG. 4 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible contoured-shaped perimeter weighting system;

FIG. 5 is a partial cross-sectional view of a portion of the preferred embodiment golf ball depicted in FIG. 3 illustrating a preferred configuration for a weighting system;

FIG. 6 is a partial cross-sectional view of a portion of the preferred embodiment golf ball depicted in FIG. 3 illustrating another preferred configuration for a weighting system;



FIG. 7 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible pentagon-shaped perimeter weighting system;

FIG. 8 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible radiused pentagon-shaped perimeter weighting system;

FIG. 9 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible single stripe-shaped perimeter weighting system;

FIG. 10 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible double stripe-shaped perimeter weighting system;

FIG. 11 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible multi stripe-shaped perimeter weighting system;

FIG. 12 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible stripe and dimple-shaped perimeter weighting system;

FIG. 13 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible ring-shaped perimeter weighting system;

FIG. 14 is an elevational view of a preferred embodiment golf ball in accordance with the present invention utilizing a visible spiral-shaped perimeter weighting system;

FIG. 15 is a partial cross-sectional view of a preferred embodiment golf ball in accordance with the present invention having a viewing window formed along the outer surface of the ball;

FIG. 16 is a partial cross-sectional view of a preferred embodiment golf ball in accordance with the present invention having a viewing window formed along the outer surface of the ball;

FIG. 17 is a partial cross-sectional view of a preferred embodiment golf ball in accordance with the present invention having a viewing window formed along the outer surface of the ball;

FIG. 18 is a partial cross-sectional view of a preferred embodiment golf ball in accordance with the present invention having a viewing window formed along the outer surface of the ball;

FIG. 19 is a block diagram illustrating a preferred technique for forming a visible region or viewing window along the exterior of a golf ball; and

FIG. 20 is a block diagram illustrating another preferred technique for forming a visible region or viewing window along the exterior of a golf ball.

#### DESCRIPTION OF THE PREFERRED EMBODIMENTS

The present invention is directed to improved multi-layer golf ball compositions and the resulting regulation balls produced using those compositions. In this regard, a smaller and lighter core is produced and metal particles, or other heavy weight filler materials, are included in the cover compositions. This results in a molded golf ball exhibiting enhanced perimeter weighting. Preferably, the particles are included in a relatively thick inner cover layer (or mantle) of a solid, three-piece multi-layered golf ball. In another preferred embodiment, the particles or other weighting material are disposed in an outer layer. Most preferably, the weighting material is viewable or otherwise visible along the ball's exterior. The size and weight of the core is reduced in order

to produce an overall golf ball which meets, or is less than, the 1.62 ounce maximum weight limitation specified by the United States Golf Association.

It has been found that the combination of the selection of materials and unique approach of the present invention produces a golf ball with an increased moment of inertia and/or a greater radius of gyration and thus generates lower initial spin. This results in a golf ball exhibiting enhanced distance without substantially effecting the feel and durability characteristics of the ball.

Preferably, the multi-layer golf ball covers of the present invention include a first or inner layer or ply of a hard, high modulus material (i.e., flexural modulus of about 15,000, or greater psi (ASTM D-790) and a hardness of at least about 60 (more desirably 65 or more on the Shore D scale (ASTM D-2240)) such as a blend of one or more hard (high or low acid) ionomer resins. Additionally, included in the multi-layer golf balls is a second or outer layer or ply comprised of a comparatively softer, low modulus material (i.e., flexural modulus of about 1,000 to about 10,000 psi (ASTM D-790) and Shore D hardness of about 65 or less, more desirably 60 or less). Examples of such materials include a blend of one or more soft ionomer resins or other non-ionomeric thermoplastic or thermosetting elastomers such as polyurethane or polyester elastomer. Metal particles and other heavy weight filler materials (from about 1 to about 100 parts per hundred parts resin (phr), preferably from about 4 to about 51 phr, and most preferably from about 10 to about 25 phr) are included in the first or inner cover layer in order to enhance the moment of inertia of the golf ball. Such heavy weight filler materials may also be provided in the outer cover layer in these proportions. The multi-layer golf balls of the invention can be of standard or enlarged size.

More preferably, the inner layer or ply of the golf ball of the invention includes a blend of high acid ionomer resins (greater than 16 weight percent acid) or a blend of high modulus low acid ionomers and has a Shore D hardness of 65 or greater. Various amounts of metallic particles or other heavy weight filler materials are included in the inner cover layer, and the size and weight of the core are reduced in order to produce selective variations in the moment of inertia of the ball. The outer cover layer preferably comprises a blend of low modulus ionomer resins or is comprised of polyurethane and has a Shore D hardness of about 45 to 55 (i.e., Shore C hardness of about 65 to 75).

In this regard, it has been found that multi-layer golf balls can be produced having inner and outer cover layers which exhibit improved C.O.R. values and have greater travel distance in comparison with balls made from a single cover layer. In addition, it has been found that use of a softer outer layer adds to the desirable "feel" and a higher spin rate while maintaining respectable resiliency. The soft outer layer allows the cover to deform more during impact and increases the area of contact between the club face and the cover, thereby imparting additional spin on the ball. As a result, the soft cover provides a multi-layer ball with a balata-like feel and spin characteristics with improved distance and durability.

It has now been determined that the travel distance of such multi-layer golf balls can be further improved without substantially sacrificing the feel and durability characteristics of the ball through the inclusion of metal particles or other heavy metal filler materials in the inner cover compositions. The metal particles or fragments increase the weight of the interior perimeter of a golf ball in comparison

to the central core. Further, the core is also made smaller and lighter in order to conform with the weight requirements of the U.S.G.A. This combination of weight displacement increases the moment of inertia and/or moves the radius of gyration of the ball closer to the outer surface of the ball.

Consequently, selective adjustments in weight arrangement will produce different moments of inertia and/or radii of gyration. The overall result is the production of a lower initial spinning multi-layer golf ball which travels farther while maintaining the feel and durability characteristics desired by a golf ball utilized in regulation play.

The moment of inertia of a golf ball (also known as rotational inertia) is the sum of the products formed by multiplying the mass (or sometimes the area) of each element of a figure by the square of its distance from a specified line such as the center of a golf ball. This property is directly related to the radius of gyration of a golf ball which is the square root of the ratio of the moment of inertia of a golf ball about a given axis to its mass. It has been found that the greater the moment of inertia (or the farther the radius of gyration is to the center of the ball) the lower the spin rate is of the ball.

The present invention is directed, in part, to increasing the moment of inertia of a multi-layered golf ball by varying the weight arrangement of one or more of the cover, the inner layer, and the core components. By varying the weight, size and density of the components of the golf ball, the moment of inertia of a golf ball can be increased. Such a change can occur in a multi-layered golf ball, including a ball containing one or more cover layers, to enhance distance due to the production of less side spin and improved roll.

Accordingly, the present invention is directed to an improved multi-layer cover which produces, upon molding each layer around a core (preferably a smaller and lighter solid core) to formulate a multi-layer cover, a golf ball exhibiting enhanced distance (i.e., improved resilience, less side spin, improved roll) without adversely affecting, and in many instances, improving the ball's feel (hardness/softness) and/or durability (i.e., cut resistance, fatigue resistance, etc.) characteristics.

Referring to FIGS. 1 and 2, a preferred embodiment golf ball in accordance with the present invention is illustrated. This preferred embodiment golf ball comprises a multi-layered cover 12 disposed over a core 10, and method for making same. Preferably the core 10 is a solid core, although a wound core having the desired characteristics can also be used.

The multi-layered cover 12 comprises two layers: a first or inner layer or ply 14 and a second or outer layer or ply 16. The inner layer 14 is comprised of a hard, high modulus (flexural modulus of 15,000 to 150,000), low or high acid (i.e. greater than 16 weight percent acid) ionomer resin or ionomer blend. Preferably, the inner layer is comprised of a blend of two or more high acid (i.e. at least 16 weight percent acid) ionomer resins neutralized to various extents by different metal cations. The inner cover layer may or may not include a metal stearate (e.g., zinc stearate) or other metal fatty acid salt. The purpose of the metal stearate or other metal fatty acid salt is to lower the cost of production without affecting the overall performance of the finished golf ball.

The inner layer compositions include the high acid ionomers such as those recently developed by E. I. DuPont de Nemours & Company under the trademark "Surlyn®" and by Exxon Corporation under the trademark "Escor®" or trade name "lotek", or blends thereof. Examples of compo-

sitions which may be used as the inner layer herein are set forth in detail in copending U.S. Ser. No. 07/776,803 filed Oct. 15, 1991 embodied in U.S. Ser. Nos. 08/723,285 filed on May 26, 1998; and 08/596,690 filed on Feb. 5, 1996; and Ser. No. 07/901,660 filed Jun. 19, 1992, embodied in U.S. Ser. Nos. 08/601,380 filed Feb. 14, 1996 and 08/412,051 filed Mar. 28, 1995, all of which are incorporated herein by reference. Of course, the inner layer high acid ionomer compositions are not limited in any way to those compositions set forth in said copending applications. For example, the high acid ionomer resins recently developed by Spalding & Evenflo Companies, Inc., the assignee of the present invention, and disclosed in U.S. Ser. No. 07/901,660, filed Jun. 19, 1992, incorporated herein by reference, may also be utilized to produce the inner layer of the multi-layer cover used in the present invention.

The high acid ionomers which may be suitable for use in formulating the inner layer compositions of the subject invention are ionic copolymers which are the metal, i.e., sodium, zinc, magnesium, etc., salts of the reaction product of an olefin having from about 2 to 8 carbon atoms and an unsaturated monocarboxylic acid having from about 3 to 8 carbon atoms. Preferably, the ionomeric resins are copolymers of ethylene and either acrylic or methacrylic acid. In some circumstances, an additional comonomer such as an acrylate ester (i.e., iso- or n-butylacrylate, etc.) can also be included to produce a softer terpolymer. The carboxylic acid groups of the copolymer are partially neutralized (i.e., approximately 10-75%, preferably 30-70%) by the metal ions. Each of the high acid ionomer resins which may be included in the inner layer cover compositions of the invention contains greater than about 16% by weight of a carboxylic acid, preferably from about 17% to about 25% by weight of a carboxylic acid, more preferably from about 18% to about 21.5% by weight of a carboxylic acid.

Although the inner layer cover composition preferably includes a high acid ionomeric resin and the scope of the patent embraces all known high acid ionomeric resins falling within the perimeters set forth above, only a relatively limited number of these high acid ionomeric resins have recently become commercially available.

The high acid ionomeric resins available from Exxon under the designation "Escor®" and or "lotek", are somewhat similar to the high acid ionomeric resins available under the "Surlyn®" trademark. However, since the Escor®/lotek ionomeric resins are sodium or zinc salts of poly(ethylene-acrylic acid) and the "Surlyn®" resins are zinc, sodium, magnesium, etc. salts of poly(ethylene-methacrylic acid), distinct differences in properties exist.

Examples of the high acid methacrylic acid based ionomers found suitable for use in accordance with this invention include Surlyn® AD-8422 (sodium cation), Surlyn® 8162 (zinc cation), Surlyn® SEP-503-1 (zinc cation), and Surlyn® SEP-503-2 (magnesium cation). According to DuPont, all of these ionomers contain from about 18.5 to about 21.5% by weight methacrylic acid.

More particularly, Surlyn® AD-8422 is currently commercially available from DuPont in a number of different grades (i.e., AD-8422-2, AD-8422-3, AD-8422-5, etc.) based upon differences in melt index. According to DuPont, Surlyn® AD-8422 offers the following general properties when compared to Surlyn®8920, the stiffest, hardest of all on the low acid grades (referred to as "hard" ionomers in U.S. Pat. No. 4,884,814), as set forth below in Table 1:

TABLE 1

	LOW ACID (15 wt % Acid)		HIGH ACID (>20 wt % Acid)
	SURLYN® 8920	SURLYN® 8422-2	SURLYN® 8422-3
<b>IONOMER</b>			
Cation	Na	Na	Na
Melt Index	1.2	2.8	1.0
Sodium, Wt %	2.3	1.9	2.4
Base Resin MI	60	60	60
MP <sup>1</sup> , ° C.	88	86	85
FP <sup>1</sup> , ° C.	47	48.5	45
<b>COMPRESSION MOLDING<sup>2</sup></b>			
Tensile Break, psi	4350	4190	5330
Yield, psi	2880	3670	3590
Elongation, %	315	263	289
Flex Mod, K psi	53.2	76.4	88.3
Shore D hardness	66	67	68

<sup>1</sup>DSC second heat, 10° C./min heating rate.

<sup>2</sup>Samples compression molded at 150° C. annealed 24 hours at 60° C. 8422-2, -3 were homogenized at 190° C. before molding.

In comparing Surlyn® 8920 to Surlyn® 8422-2 and Surlyn® 8422-3, it is noted that the high acid Surlyn® 8422-2 and 8422-3 ionomers have a higher tensile yield, lower elongation, slightly higher Shore D hardness and much higher flexural modulus. Surlyn® 8920 contains 15 weight percent methacrylic acid and is 59% neutralized with sodium.

In addition, Surlyn® SEP-503-1 (zinc cation) and Surlyn® SEP-503-2 (magnesium cation) are high acid zinc and magnesium versions of the Surlyn® AD 8422 high acid ionomers. When compared to the Surlyn® AD 8422 high acid ionomers, the Surlyn SEP-503-1 and SEP-503-2 ionomers can be defined as follows in Table 2:

TABLE 2

Surlyn® Ionomer	Ion	Melt Index	Neutralization %
AD 8422-3	Na	1.0	45
SEP 503-1	Zn	0.8	38
SEP 503-2	Mg	1.8	43

Furthermore, Surlyn® 8162 is a zinc cation ionomer resin containing approximately 20% by weight (i.e. 18.5–21.5% weight) methacrylic acid copolymer that has been 30–70% neutralized. Surlyn® 8162 is currently commercially available from DuPont.

Examples of the high acid acrylic acid based ionomers suitable for use in the present invention also include the Escor® or lotek high acid ethylene acrylic acid ionomers produced by Exxon. In this regard, Escor® or lotek 959 is a sodium ion neutralized ethylene-acrylic acid copolymer. According to Exxon, loteks 959 and 960 contain from about 19.0 to about 21.0% by weight acrylic acid with approximately 30 to about 70 percent of the acid groups neutralized with sodium and zinc ions, respectively. The physical properties of these high acid acrylic acid based ionomers are as follows in Table 3:

TABLE 3

PROPERTY	ESCOR® (IOTEK) 959	ESCOR® (IOTEK) 960
Melt Index, g/10 min	2.0	1.8
Cation	Sodium	Zinc
Melting Point, ° F.	172	174
Vicat Softening Point, ° F.	130	131
Tensile @ Break, psi	4600	3500
Elongation E Break, %	325	430
Hardness, Shore D	66	57
Flexural Modulus, psi	66,000	27,000

Additional high acid hard ionomer resins are also available from Exxon such as lotek 1002 and lotek 1003. lotek 1002 is a sodium ion neutralized high acid ionomer (i.e., 18% by weight acid) and lotek 1003 is a zinc ion neutralized high acid ionomer (i.e., 18% by weight acid). The properties of these ionomers are set forth below in Table 4:

TABLE 4

Property	Unit	Value	Method
<b>IOTEK 1002</b>			
<u>General properties</u>			
Melt index	g/10 min	1.6	ASTM-D 1238
Density	kg/m <sup>3</sup>		ASTM-D 1505
Cation type		Na	
Melting point	° C.	83.7	ASTM-D 3417
Crystallization point	° C.	43.2	ASTM-D 3417
<u>Plaque properties</u>			
Tensile at break	MPa	31.7	ASTM-D 638
Tensile at yield	MPa	22.5	ASTM-D 638
Elongation at break	%	348	ASTM-D 638
1% Secant modulus	MPa	418	ASTM-D 638
1% Flexural modulus	MPa	380	ASTM-D 790
Hardness Shore D		62	ASTM-D 2240
Vicat softening point	° C.	51.5	ASTM-D 1525
<b>IOTEK 1003</b>			
<u>General properties</u>			
Melt index	g/10 min	1.1	ASTM-D 1238
Density	kg/m <sup>3</sup>		ASTM-D 1505
Cation type		Zn	EXXON
Melting point	° C.	82	ASTM-D 3417
Crystallization point	° C.	51.5	ASTM-D 3417
<u>Plaque properties</u>			
Tensile at break	MPa	24.8	ASTM-D 638
Tensile at yield	MPa	14.8	ASTM-D 638
Elongation at break	%	387	ASTM-D 638
1% Secant modulus	MPa	145	ASTM-D 638
1% Flexural modulus	MPa	147	ASTM-D 790
Hardness Shore D		54	ASTM-D 2240
Vicat softening point	° C.	56	ASTM-D 1525

Furthermore, as a result of the development of a number of new high acid ionomers neutralized to various extents by several different types of metal cations, such as by manganese, lithium, potassium, calcium and nickel cations, several new high acid ionomers and/or high acid ionomer blends besides sodium, zinc and magnesium high acid ionomers or ionomer blends are now available for golf ball cover production. It has been found that these new cation neutralized high acid ionomer blends produce inner cover layer compositions exhibiting enhanced hardness and resilience due to synergies which occur during processing. Consequently, the metal cation neutralized high acid ionomer resins recently produced can be blended to produce

substantially harder inner cover layers for multi-layered golf balls having higher C.O.R.'s than those produced by the low acid ionomer inner cover compositions presently commercially available.

More particularly, several new metal cation neutralized high acid ionomer resins have been produced by neutralizing, to various extents, high acid copolymers of an alpha-olefin and an alpha, beta-unsaturated carboxylic acid with a wide variety of different metal cation salts. This discovery is the subject matter of U.S. application Ser. No. 07/901,680, incorporated herein by reference. It has been found that numerous new metal cation neutralized high acid ionomer resins can be obtained by reacting a high acid copolymer (i.e. a copolymer containing greater than 16% by weight acid, preferably from about 17 to about 25 weight percent acid, and more preferably about 20 weight percent

weight ethylene and from 0 to about 40% by weight of a softening comonomer. Preferably, the copolymer contains about 20% by weight unsaturated carboxylic acid and about 80% by weight ethylene. Most preferably, the copolymer contains about 20% acrylic acid with the remainder being ethylene.

Along these lines, examples of the preferred high acid base copolymers which fulfill the criteria set forth above, are a series of ethylene-acrylic copolymers which are commercially available from The Dow Chemical Company, Midland, Mich., under the "Primacor" designation. These high acid base copolymers exhibit the typical properties set forth below in Table 5.

TABLE 5

Typical Properties of Primacor Ethylene-Acrylic Acid Copolymers							
GRADE ASTM	PERCENT ACID	DENSITY, g/cc D-792	MELT INDEX, g/10 min D-1238	TENSILE YD. ST (psi) D-638	FLEXURAL MODULUS (psi) D-790	VICAT SOFT PT (° C.) D-1525	SHORE D HARDNESS D-2240
5980	20.0	0.958	300.0	—	4800	43	50
5990	20.0	0.955	1300.0	650	2600	40	42
5990	20.0	0.955	1300.0	650	3200	40	42
5981	20.0	0.960	300.0	900	3200	46	48
5981	20.0	0.960	300.0	900	3200	46	48
5983	20.0	0.958	500.0	850	3100	44	45
5991	20.0	0.953	2600.0	635	2600	38	40

<sup>1</sup>The Melt Index values are obtained according to ASTM D-1238, at 190° C.

acid), with a metal cation salt capable of ionizing or neutralizing the copolymer to the extent desired (i.e. from about 10% to 90%).

The base copolymer is made up of greater than 16% by weight of an alpha, beta-unsaturated carboxylic acid and an alpha-olefin. Optionally, a softening comonomer can be included in the copolymer. Generally, the alpha-olefin has from 2 to 10 carbon atoms and is preferably ethylene, and the unsaturated carboxylic acid is a carboxylic acid having from about 3 to 8 carbons. Examples of such acids include acrylic acid, methacrylic acid, ethacrylic acid, chloroacrylic acid, crotonic acid, maleic acid, fumaric acid, and itaconic acid, with acrylic acid being preferred.

The softening comonomer that can be optionally included in the invention may be selected from the group consisting of vinyl esters of aliphatic carboxylic acids wherein the acids have 2 to 10 carbon atoms, vinyl ethers wherein the alkyl groups contains 1 to 10 carbon atoms, and alkyl acrylates or methacrylates wherein the alkyl group contains 1 to 10 carbon atoms. Suitable softening comonomers include vinyl acetate, methyl acrylate, methyl methacrylate, ethyl acrylate, ethyl methacrylate, butyl acrylate, butyl methacrylate, or the like.

Consequently, examples of a number of copolymers suitable for use to produce the high acid ionomers included in the present invention include, but are not limited to, high acid embodiments of an ethylene/acrylic acid copolymer, an ethylene/methacrylic acid copolymer, an ethylene/itaconic acid copolymer, an ethylene/maleic acid copolymer, an ethylene/methacrylic acid/vinyl acetate copolymer, an ethylene/acrylic acid/vinyl alcohol copolymer, etc. The base copolymer broadly contains greater than 16% by weight unsaturated carboxylic acid, from about 30 to about 83% by

Due to the high molecular weight of the Primacor 5981 grade of the ethylene-acrylic acid copolymer, this copolymer is the more preferred grade utilized in the invention.

The metal cation salts utilized in the invention are those salts which provide the metal cations capable of neutralizing, to various extents, the carboxylic acid groups of the high acid copolymer. These include acetate, oxide or hydroxide salts of lithium, calcium, zinc, sodium, potassium, nickel, magnesium, and manganese.

Examples of such lithium ion sources are lithium hydroxide monohydrate, lithium hydroxide, lithium oxide and lithium acetate. Sources for the calcium ion include calcium hydroxide, calcium acetate and calcium oxide. Suitable zinc ion sources are zinc acetate dihydrate and zinc acetate, a blend of zinc oxide and acetic acid. Examples of sodium ion sources are sodium hydroxide and sodium acetate. Sources for the potassium ion include potassium hydroxide and potassium acetate. Suitable nickel ion sources are nickel acetate, nickel oxide and nickel hydroxide. Sources of magnesium include magnesium oxide, magnesium hydroxide, magnesium acetate. Sources of manganese include manganese acetate and manganese oxide.

The new metal cation neutralized high acid ionomer resins are produced by reacting the high acid base copolymer with various amounts of the metal cation salts above the crystalline melting point of the copolymer, such as at a temperature from about 200° F. to about 500° F., preferably from about 250° F. to about 350° F. under high shear conditions at a pressure of from about 10 psi to 10,000 psi. Other well known blending techniques may also be used. The amount of metal cation salt utilized to produce the new metal cation neutralized high acid based ionomer resins is the quantity which provides a sufficient amount of the metal

cations to neutralize the desired percentage of the carboxylic acid groups in the high acid copolymer. The extent of neutralization is generally from about 10% to about 90%.

As indicated below in Table 6, a number of new types of metal cation neutralized high acid ionomers can be obtained from the above indicated process. These include new high acid ionomer resins neutralized to various extents with manganese, lithium, potassium, calcium and nickel cations. In addition, when a high acid ethylene/acrylic acid copolymer is utilized as the base copolymer component of the invention and this component is subsequently neutralized to various extents with the metal cation salts producing acrylic acid based high acid ionomer resins neutralized with cations such as sodium, potassium, lithium, zinc, magnesium, manganese, calcium and nickel, several new cation neutralized acrylic acid based high acid ionomer resins are produced.

TABLE 6

Formulation No.	Metal Cation Neutralized High Acid Ionomers		Melt Index	C.O.R.	Shore D Hardness
	Wt-% Cation Salt	Wt-% Neutralization			
1(NaOH)	6.98	67.5	0.9	.804	71
2(NaOH)	5.66	54.0	2.4	.806	73
3(NaOH)	3.84	35.9	12.2	.812	69
4(NaOH)	2.91	27.0	17.5	.812	(brittle)
5(MnAc)	19.6	71.7	7.5	.809	73
6(MnAc)	23.1	88.3	3.5	.814	77
7(MnAc)	15.3	53.0	7.5	.810	72
8(MnAc)	26.5	106	0.7	.813	(brittle)
9(LiOH)	4.54	71.3	0.6	.810	74
10(LiOH)	3.38	52.5	4.2	.818	72
11(LiOH)	2.34	35.9	18.6	.815	72
12(KOH)	5.30	36.0	19.3	Broke	70
13(KOH)	8.26	57.9	7.18	.804	70
14(KOH)	10.7	77.0	4.3	.801	67
15(ZnAc)	17.9	71.5	0.2	.806	71
16(ZnAc)	13.9	53.0	0.9	.797	69
17(ZnAc)	9.91	36.1	3.4	.793	67
18(MgAc)	17.4	70.7	2.8	.814	74
19(MgAc)	20.6	87.1	1.5	.815	76
20(MgAc)	13.8	53.8	4.1	.814	74
21(CaAc)	13.2	69.2	1.1	.813	74
22(CaAc)	7.12	34.9	10.1	.808	70
23(MgO)	2.91	53.5	2.5	.813	
24(MgO)	3.85	71.5	2.8	.808	
25(MgO)	4.76	89.3	1.1	.809	
26(MgO)	1.96	35.7	7.5	.815	
27(NiAc)	13.04	61.1	0.2	.802	71
28(NiAc)	10.71	48.9	0.5	.799	72
29(NiAc)	8.26	36.7	1.8	.796	89
30(NiAc)	5.66	24.4	7.5	.786	64

Controls:

50/50 Blend of Ioteks 8000/7030 C.O.R. = .810/65 Shore D Hardness

DuPont High Acid Surlyn® 8422 (Na) C.O.R. = .811/70 Shore D Hardness

DuPont High Acid Surlyn® 8162 (Zn) C.O.R. = .807/65 Shore D Hardness

Exxon High Acid Iotek EX-960 (Zn) C.O.R. = .796/65 Shore D Hardness

Control for Formulations 23-26 is 50/50 Iotek 8000/7030.

C.O.R. = .814, Formulation 26 C.O.R. was normalized to that control

accordingly

Control for Formulation Nos. 27-30 is 50/50 Iotek 8000/7030, C.O.R. = .807

When compared to low acid versions of similar cation neutralized ionomer resins, the new metal cation neutralized high acid ionomer resins exhibit enhanced hardness, modulus and resilience characteristics. These are properties that are particularly desirable in a number of thermoplastic fields, including the field of golf ball manufacturing.

When utilized in the construction of the inner layer of a multi-layered golf ball, it has been found that the new acrylic acid based high acid ionomers extend the range of hardness beyond that previously obtainable while maintaining the beneficial properties (i.e. durability, click, feel, etc.) of the softer low acid ionomer covered balls, such as balls produced utilizing the low acid ionomers disclosed in U.S. Pat. Nos. 4,884,814 and 4,911,451.

Moreover, as a result of the development of a number of new acrylic acid based high acid ionomer resins neutralized to various extents by several different types of metal cations, such as manganese, lithium, potassium, calcium and nickel cations, several new ionomers or ionomer blends are now available for production of an inner cover layer of a multi-layered golf ball. By using these high acid ionomer resins, harder, stiffer inner cover layers having higher C.O.R.s, and thus longer distance, can be obtained.

More preferably, it has been found that when two or more of the above-indicated high acid ionomers, particularly blends of sodium and zinc high acid ionomers, are processed to produce the covers of multi-layered golf balls, (i.e., the inner cover layer herein) the resulting golf balls will travel farther than previously known multi-layered golf balls produced with low acid ionomer resin covers due to the balls' enhanced coefficient of restitution values.

The low acid ionomers which may be suitable for use in formulating the inner layer compositions of the subject invention are ionic copolymers which are the metal, i.e., sodium, zinc, magnesium, etc., salts of the reaction product of an olefin having from about 2 to 8 carbon atoms and an unsaturated monocarboxylic acid having from about 3 to 8 carbon atoms. Preferably, the ionomeric resins are copolymers of ethylene and either acrylic or methacrylic acid. In some circumstances, an additional comonomer such as an acrylate ester (i.e., iso- or n-butylacrylate, etc.) can also be included to produce a softer terpolymer. The carboxylic acid groups of the copolymer are partially neutralized (i.e., approximately 10-75%, preferably 30-70%) by the metal ions. Each of the low acid ionomer resins which may be included in the inner layer cover compositions of the invention contains 16% by weight or less of a carboxylic acid.

When utilized in the construction of the inner layer of an additional embodiment of a multi-layered golf ball of the present invention, it has been found that the low acid ionomer blends extend the range of compression and spin rates beyond that previously obtainable. More preferably, it has been found that when two or more low acid ionomers, particularly blends of sodium and zinc high acid ionomers, are processed to produce the covers of multi-layered golf balls, (i.e., the inner cover layer herein) the resulting golf balls will travel farther and at an enhanced spin rate than previously known multi-layered golf balls. Such an improvement is particularly noticeable in enlarged or oversized golf balls.

With respect to the outer layer 16 of the preferred embodiment multi-layered cover of the present invention, the outer cover layer is comparatively softer than the inner layer. The softness provides for the enhanced feel and playability characteristics typically associated with balata or balata-blend balls. The outer layer or ply is comprised of a relatively soft, low modulus (about 1,000 psi to about 10,000

psi) and low acid (less than 16 weight percent acid) ionomer, ionomer blend or a non-ionomeric elastomer such as, but not limited to, a polyurethane, a polyester elastomer such as that marketed by DuPont under the trademark Hytrel®, a polyurethane sold by BASF under the designation Baytec® or a polyester amide such as that marketed by Elf Atochem S. A. under the trademark Pebax®. The outer layer is fairly thin (i.e. from about 0.010 to about 0.110 in thickness, more desirably 0.03 to 0.06 inches in thickness for a 1.680 inch ball and 0.04 to 0.07 inches in thickness for a 1.72 inch ball), but thick enough to achieve desired playability characteristics while minimizing expense.

Preferably, the outer layer includes a blend of hard and soft (low acid) ionomer resins such as those described in U.S. Pat. Nos. 4,884,814 and 5,120,791, both incorporated herein by reference. Specifically, a desirable material for use in molding the outer layer comprises a blend of a high modulus (hard), low acid, ionomer with a low modulus (soft), low acid, ionomer to form a base ionomer mixture. A high modulus ionomer herein is one which measures from about 15,000 to about 70,000 psi as measured in accordance with ASTM method D-790. The hardness may be defined as at least 50 on the Shore D scale as measured in accordance with ASTM method D-2240.

A low modulus ionomer suitable for use in the outer layer blend has a flexural modulus measuring from about 1,000 to about 10,000 psi, with a hardness of about 20 to about 40 on the Shore D scale.

The hard ionomer resins utilized to produce the outer cover layer composition hard/soft blends include ionic copolymers which are the sodium, zinc, magnesium or lithium salts of the reaction product of an olefin having from

be blended into the outer cover layer compositions in order to produce the desired properties of the resulting golf balls.

As discussed earlier herein, the hard ionomeric resins introduced under the designation Escor® and sold under the designation "lotek" are somewhat similar to the hard ionomeric resins sold under the Surlyn® trademark. However, since the "lotek" ionomeric resins are sodium or zinc salts of poly(ethylene-acrylic acid) and the Surlyn® resins are zinc or sodium salts of poly(ethylene-methacrylic acid) some distinct differences in properties exist. As more specifically indicated in the data set forth below, the hard "lotek" resins (i.e., the acrylic acid based hard ionomer resins) are the more preferred hard resins for use in formulating the outer layer blends for use in the present invention. In addition, various blends of "lotek" and Surlyn® hard ionomeric resins, as well as other available ionomeric resins, may be utilized in the present invention in a similar manner.

Examples of commercially available hard ionomeric resins which may be used in the present invention in formulating the inner and outer cover blends include the hard sodium ionic copolymer sold under the trademark Surlyn®8940 and the hard zinc ionic copolymer sold under the trademark Surlyn®9910. Surlyn®8940 is a copolymer of ethylene with methacrylic acid and about 15 weight percent acid which is about 29 percent neutralized with sodium ions. This resin has an average melt flow index of about 2.8. Surlyn®9910 is a copolymer of ethylene and methacrylic acid with about 15 weight percent acid which is about 58 percent neutralized with zinc ions. The average melt flow index of Surlyn®9910 is about 0.7. The typical properties of Surlyn®9910 and 8940 are set forth below in Table 7:

TABLE 7

Typical Properties of Commercially Available Hard Surlyn® Resins Suitable for Use in the Inner and Outer Layer Blends of the Present Invention

	ASTM D	8940	9910	8920	8528	9970	9730
Cation Type		Sodium	Zinc	Sodium	Sodium	Zinc	Zinc
Melt flow index, gms/10 min.	D-1238	2.8	0.7	0.9	1.3	14.0	1.6
Specific Gravity, g/cm <sup>3</sup>	D-792	0.95	0.97	0.95	0.94	0.95	0.95
Hardness, Shore D	D-2240	66	64	66	60	62	63
Tensile Strength, (kpsi), MPa	D-638	(4.8) 33.1	(3.6) 24.8	(5.4) 37.2	(4.2) 29.0	(3.2) 22.0	(4.1) 28.0
Elongation, %	D-638	470	290	350	450	460	460
Flexural Modulus, (kpsi) MPa	D-790	(51) 350	(48) 330	(55) 380	(32) 220	(28) 190	(30) 210
Tensile Impact (23° C.) KJ/m <sup>2</sup> (ft.-lbs./in <sup>2</sup> )	D-1822S	1020 (485)	1020 (485)	865 (410)	1160 (550)	760 (360)	1240 (590)
Vicat Temperature, ° C.	D-1525	63	82	58	73	61	73

2 to 8 carbon atoms and an unsaturated monocarboxylic acid having from 3 to 8 carbon atoms. The carboxylic acid groups of the copolymer may be totally or partially (i.e. approximately 15–75 percent) neutralized.

The hard ionomeric resins are likely copolymers of ethylene and either acrylic and/or methacrylic acid, with copolymers of ethylene and acrylic acid being the most preferred. Two or more types of hard ionomeric resins may

Examples of the more pertinent acrylic acid based hard ionomer resin suitable for use in the present inner and outer cover composition sold under the "lotek" tradename by the Exxon Corporation include lotek 4000, lotek 4010, lotek 8000, lotek 8020 and lotek 8030. The typical properties of these and other lotek hard ionomers suited for use in formulating the inner and outer layer cover compositions are set forth below in Table 8:

TABLE 8

Typical Properties of Iotek Ionomers							
ASTM Method	Units	4000	4010	8000	8020	8030	
<u>Resin Properties</u>							
Cation type			zinc	zinc	sodium	sodium	sodium
Melt index	D-1238	g/10 min.	2.5	1.5	0.8	1.6	2.8
Density	D-1505	kg/m <sup>3</sup>	963	963	954	960	960
Melting Point	D-3417	° C.	90	90	90	87.5	87.5
Crystallization Point	D-3417	° C.	62	64	56	53	55
Vicat Softening Point	D-1525	° C.	62	63	61	64	67
% Weight Acrylic Acid			16		11		
% of Acid Groups			30		40		
cation neutralized							
(3 mm thick, compression molded)							
Tensile at break	D-638	MPa	24	26	36	31.5	28
Yield point	D-638	MPa	none	none	21	21	23
Elongation at break	D-638	%	395	420	350	410	395
1% Secant modulus	D-638	MPa	160	160	300	350	390
<u>Plaque Properties</u>							
Shore Hardness D	D-2240	—	55	55	61	58	59
<u>Film Properties</u> (50 micron film 2.2:1 Blow-up ratio)							
<u>Tensile at Break</u>							
MD	D-882	MPa	41	39	42	52	47.4
TD	D-882	MPa	37	38	38	38	40.5
<u>Yield point</u>							
MD	D-882	MPa	15	17	17	23	21.6
TD	D-882	MPa	14	15	15	21	20.7
<u>Elongation at Break</u>							
MD	D-882	%	310	270	260	295	305
TD	D-882	%	360	340	280	340	345
<u>1% Secant modulus</u>							
MD	D-882	MPa	210	215	390	380	380
TD	D-882	MPa	200	225	380	350	345
Dart Drop Impact	D-1709	g/micron	12.4	12.5	20.3		
ASTM Method	Units		7010	7020	7030		
<u>Resin Properties</u>							
Cation type			zinc	zinc	zinc		
Melt Index	D-1238	g/10 min.		0.8	1.5	2.5	
Density	D-1505	kg/m <sup>3</sup>	960	960	960		
Melting Point	D-3417	° C.	90	90	90		
Crystallization Point	D-3417	° C.	—	—	—		
Vicat Softening Point	D-1525	° C.	60	63	62.5		
% Weight Acrylic Acid			—	—	—		
% of Acid Groups			—	—	—		
Cation Neutralized							
<u>Plaque Properties</u>							
(3 mm thick, compression molded)							
Tensile at break	D-638	MPa	38	38	38		
Yield Point	D-638	MPa	none	none	none		
Elongation at break	D-638	%	500	420	395		
1% Secant modulus	D-638	MPa	—	—	—		
Shore Hardness D	D-2240	—	57	55	55		

Comparatively, soft ionomers are used in formulating the hard/soft blends of the inner and outer cover compositions. These ionomers include acrylic acid based soft ionomers.

They are generally characterized as comprising sodium or zinc salts of a terpolymer of an olefin having from about 2 to 8 carbon atoms, acrylic acid, and an unsaturated monomer

of the acrylate ester class having from 1 to 21 carbon atoms. The soft ionomer is preferably a zinc based ionomer made from an acrylic acid base polymer in an unsaturated monomer of the acrylate ester class. The soft (low modulus) ionomers have a hardness from about 20 to about 40 as measured on the Shore D scale and a flexural modulus from about 1,000 to about 10,000, as measured in accordance with ASTM method D-790.

Certain ethylene-acrylic acid based soft ionomer resins developed by the Exxon Corporation under the designation "lotek 7520" (referred to experimentally by differences in neutralization and melt indexes as LDX 195, LDX 196, LDX 218 and LDX 219) may be combined with known hard ionomers such as those indicated above to produce the inner and outer cover layers. The combination produces higher C.O.R.s at equal or softer hardness, higher melt flow (which corresponds to improved, more efficient molding, i.e., fewer rejects) as well as significant cost savings versus the inner and outer layers of multi-layer balls produced by other known hard-soft ionomer blends as a result of the lower overall raw materials costs and improved yields.

While the exact chemical composition of the resins to be sold by Exxon under the designation lotek 7520 is considered by Exxon to be confidential and proprietary information, Exxon's experimental product data sheet lists the following physical properties of the ethylene acrylic acid zinc ionomer developed by Exxon and set forth below in Table 9:

TABLE 9

Physical Properties of Iotek 7520			
Property	ASTM Method	Units	Typical Value
Melt Index	D-1238	g/10 min.	2
Density	D-1505	g/cc	0.962
Cation			Zinc
Melting Point	D-3417	° C.	66
Crystallization Point	D-3417	° C.	49
Vicat Softening Point	D-1525	° C.	42
Plaque Properties (2 mm thick Compression Molded Plaques)			
Tensile at Break	D-638	MPa	10
Yield Point	D-638	MPa	None
Elongation at Break	D-638	760	
1% Secant Modulus	D-638	MPa	22
Shore D Hardness	D-2240		32
Flexural Modulus	D-790	MPa	26
Zwick Rebound	ISO 4862	%	52
De Mattia Flex Resistance	D-430	Cycles	>5000

In addition, test data indicates that lotek 7520 resins have Shore D hardnesses of about 32 to 36 (per ASTM D-2240), melt flow indexes of  $3\pm 0.5$  g/10 min (at 190° C. per ASTM D-1288), and a flexural modulus of about 2500–3500 psi (per ASTM D-790). Furthermore, testing by an independent testing laboratory by pyrolysis mass spectrometry indicates that lotek 7520 resins are generally zinc salts of a terpolymer of ethylene, acrylic acid, and methyl acrylate.

Furthermore, the inventors have found that a newly developed grade of an acrylic acid based soft ionomer available from the Exxon Corporation under the designation lotek 7510, is also effective, when combined with the hard ionomers indicated above in producing golf ball covers exhibiting higher C.O.R. values at equal or softer hardness than those produced by known hard-soft ionomer blends. In this regard, lotek 7510 has the advantages (i.e. improved flow,

higher C.O.R. values at equal hardness, increased clarity, etc.) produced by the lotek 7520 resin when compared to the methacrylic acid base soft ionomers known in the art (such as the Surlyn 8625 and the Surlyn 8629 combinations disclosed in U.S. Pat. No. 4,884,814).

In addition, lotek 7510, when compared to lotek 7520, produces slightly higher C.O.R. values at equal softness/hardness due to the lotek 7510's higher hardness and neutralization. Similarly, lotek 7510 produces better release properties (from the mold cavities) due to its slightly higher stiffness and lower flow rate than lotek 7520. This is important in production where the soft covered balls tend to have lower yields caused by sticking in the molds and subsequent punched pin marks from the knockouts.

According to Exxon, lotek 7510 is of similar chemical composition as lotek 7520 (i.e. a zinc salt of a terpolymer of ethylene, acrylic acid, and methyl acrylate) but is more highly neutralized. Based upon FTIR analysis, lotek 7520 is estimated to be about 30–40 wt.-% neutralized and lotek 7510 is estimated to be about 40–60 wt.-% neutralized. The typical properties of lotek 7510 in comparison of those of lotek 7520 are set forth below in Table 10:

TABLE 10

Physical Properties of Iotek 7510 in Comparison to Iotek 7520			
	IOTEK 7520	IOTEK 7510	
MI, g/10 min	2.0	0.8	
Density, g/cc	0.96	0.97	
Melting Point, ° F.	151	149	
Vicat Softening Point, ° F.	108	109	
Flex Modulus, psi	3800	5300	
Tensile Strength, psi	1450	1750	
Elongation, %	760	690	
Hardness, Shore D	32	35	

It has been determined that when hard/soft ionomer blends are used for the outer cover layer, good results are achieved when the relative combination is in a range of about 90 to about 10 percent hard ionomer and about 10 to about 90 percent soft ionomer. The results are improved by adjusting the range to about 75 to 25 percent hard ionomer and 25 to 75 percent soft ionomer. Even better results are noted at relative ranges of about 60 to 90 percent hard ionomer resin and about 40 to 60 percent soft ionomer resin.

Specific formulations which may be used in the cover composition are included in the examples set forth in U.S. Nos. 5,120,791 and 4,884,814. The present invention is in no way limited to those examples.

Moreover, in alternative embodiments, the outer cover layer formulation may also comprise a soft, low modulus non-ionomeric thermoplastic elastomer including a polyester polyurethane such as B.F. Goodrich Company's Estane® polyester polyurethane X-4517. According to B. F. GOODRICH, Estane® X-4517 has the following properties as set forth in Table 11:

TABLE 11

Properties of Estane ®X-4517	
Tensile	1430
100%	815
200%	1024
300%	1193
Elongation	641



TABLE 11-continued

Properties of Estane ®X-4517	
Youngs Modulus	1826
Hardness A/D	88/39
Bayshore Rebound	59
Solubility in Water	Insoluble
Melt processing temperature	>350° F. (>177° C.)
Specific Gravity (H <sub>2</sub> O = 1)	1.1-1.3

Other soft, relatively low modulus non-ionomeric thermoplastic elastomers may also be utilized to produce the outer cover layer as long as the non-ionomeric thermoplastic elastomers produce the playability and durability characteristics desired without adversely effecting the enhanced spin characteristics produced by the low acid ionomer resin compositions. These include, but are not limited to thermoplastic polyurethanes such as: Texin thermoplastic polyurethanes from Mobay Chemical Co. and the Pellethane thermoplastic polyurethanes from Dow Chemical Co.; Ionomer/rubber blends such as those in Spalding U.S. Pat. Nos. 4,986,545; 5,098,105 and 5,187,013, both of which are herein incorporated by reference; and, Hytel polyester elastomers from DuPont and pebax polyesteramides from Elf Atochem S.A.

Similarly, a castable, thermosetting polyurethane produced by BASF under the trade designation Baytec® has also shown enhanced cover formulation properties. According to BASF, Baytec® (such as Baytec® RE 832), relates to a group of reactive elastomers having outstanding wear resistance, high mechanical strength, high elasticity and good resistance to weathering, moisture and chemicals. The Baytec® RE-832 system gives the following typical physical properties as set forth below in Table 12:

TABLE 12

Property	ASTM Test Method	Unit	Value
Tear Strength Die C Stress at	D624	pli	180
100% Modulus	D412	psi	320
200% Modulus			460
300% Modulus			600
Ultimate Strength	D412	psi	900
Elongation at Break	D412	%	490
Taber Abrasion	D460, H-18	mg/1000 cycles	350
Component <sup>1</sup> Properties	Part A (Isocyanate)	Part B (Resin)	
Viscosity @ 25° C., mPa·s	2500	2100	
Density @ 25° C., g/cm	1.08	1.09	
NCO, %	9.80	—	
Hydroxyl Number, Mg KOH/g	—	88	

<sup>1</sup>Component A is a modified diphenylmethane diisocyanate (mDI) prepolymer and component B is a polyether polyol blend.

The weight of the cover layers is increased in the present invention by making the cover layers thicker and through the inclusion of about 1 to about 100 parts per 100 parts resin of metal particles and other heavy weight filler materials. As used herein, the term "heavy weight filler materials" is defined as any material having a specific gravity greater than 1.0. This term "heavy weight filler materials" is used interchangeably with the term "weighting material" as also used herein.

As noted above, it has been found that increasing the weight of the ball towards the outer perimeter produces an

increase in the ball's moment of inertia. Preferably, the particles (or flakes, fragments, fibers, etc.) of heavy filler are added to the inner cover layer as opposed to the outer cover, in order to increase the moment of inertia of the ball without affecting the ball's feel and durability characteristics. However, as described below, it may in some instances be preferred to incorporate weighting materials or heavy filler in the outer cover. This is particularly the case when producing a golf ball having a visible weighting system as described herein.

The inner layer is filled with one or more of a variety of reinforcing or non-reinforcing heavy weight fillers or fibers such as metal (or metal alloy) powders, carbonaceous materials (i.e., graphite, carbon black, cotton flock, leather fiber, etc.), glass, Kevlar® fibers (trademarked material of Du Pont for an aromatic polyamide fiber of high tensile strength and greater resistance of elongation than steel), etc. These heavy weight filler materials range in size from about 10 mesh to about 325 mesh, preferably about 20 mesh to about 325 mesh and most preferably about 100 mesh to about 325 mesh. Representatives of such metal (or metal alloy) powders include but are not limited to, bismuth powder, boron powder, brass powder, bronze powder, cobalt powder, copper powder, inconel metal powder, iron metal powder, molybdenum powder, nickel powder, stainless steel powder, titanium metal powder, zirconium oxide powder, aluminum flakes, and aluminum tadpoles. It will be understood that the foregoing materials may be in other forms besides powders.

Examples of various suitable heavy filler materials which can be included in the present invention are as follows in Table 13:

TABLE 13

Filler Type	Spec. Gravity
graphite fibers	1.5-1.8
precipitated hydrated silica	2.0
clay	2.62
talc	2.85
asbestos	2.5
glass fibers	2.55
aramid fibers (Kevlar®)	1.44
mica	2.8
calcium metasilicate	2.9
barium sulfate	4.6
zinc sulfide	4.1
silicates	2.1
diatomaceous earth	2.3
calcium carbonate	2.71
magnesium carbonate	2.20
<u>Metals and Alloys (powders)</u>	
titanium	4.51
tungsten	19.35
aluminum	2.70
bismuth	9.78
nickel	8.90
molybdenum	10.2
iron	7.86
copper	8.94
brass	8.2-8.4
boron	2.364
bronze	8.70-8.74
cobalt	8.92
beryllium	1.84
zinc	7.14
tin	7.31
<u>Metal Oxides</u>	
zinc oxide	5.57
iron oxide	5.1
aluminum oxide	4.0

TABLE 13-continued

Filler Type	Spec. Gravity
titanium dioxide	3.9-4.1
magnesium oxide	3.3-3.5
zirconium oxide	5.73
<u>Metal Stearates</u>	
zinc stearate	1.09
calcium stearate	1.03
barium stearate	1.23
lithium stearate	1.01
magnesium stearate	1.03
<u>Particulate carbonaceous materials</u>	
graphite	1.5-1.8
carbon black	1.8
natural bitumen	1.2-1.4
cotton flock	1.3-1.4
cellulose flock	1.15-1.5
leather fiber	1.2-1.4

The amount and type of heavy weight filler material utilized is dependent upon the overall characteristics of the low spinning multi-layered golf ball desired. Generally, lesser amounts of high specific gravity materials are necessary to produce an increase in the moment of inertia in comparison to low specific gravity materials. Furthermore, handling and processing conditions can also affect the type of heavy weight filler material incorporated into cover layers. In this regard, Applicant has found that the inclusion of approximately 10 phr brass powder into an inner cover layer produces the desired increase in the moment of inertia without involving substantial processing changes. Thus, 10 phr brass powder is generally, the most preferred heavy filler material at the time of this writing.

Additional materials may be added to the cover compositions (both inner and outer cover layer) of the present invention including dyes (for example, Ultramarine Blue sold by Whitaker, Clark and Daniels of South Plainsfield, N.J.) (see U.S. Pat. No. 4,679,795); pigments such as titanium dioxide, zinc oxide, barium sulfate and zinc sulfate; and optical brighteners, UV absorbers; antioxidants; anti-static agents; and stabilizers. Further, the cover compositions of the present invention may also contain softening agents, such as plasticizers, processing aids, etc., as long as the desired properties produced by the golf ball covers are not impaired.

The present invention also provides particular patterns of weighting materials disposed proximate or generally within the outer periphery of a golf ball. The use of a weighted perimeter has been found to increase a ball's moment of inertia and reduce the overall spin rate. In a most preferred embodiment, golf balls with weighted perimeters utilize a visible pattern of weighting material disposed along a portion of the outer periphery of the ball. Although not wishing to be bound to any particular theory, it is believed that characteristics and properties of a weighted perimeter ball in accordance with the present invention are affected, or at least influenced by, the shape or configuration of the pattern of weighting material along the ball's outer periphery. Moreover, for the most preferred embodiment balls utilizing a visible pattern of weighting material, the shape of such pattern can also serve as a unique identifier of the ball. Furthermore, by providing a weighting system that is visible or otherwise viewable along a golf ball's exterior, a consumer may readily determine whether a particular golf ball comprises a weighting system.

The present invention provides an array of particularly preferred patterns of weighting material. FIG. 3 illustrates a

preferred embodiment golf ball **30** in accordance with the present invention utilizing a visible star-shaped perimeter weighting system **32**. This system comprises a first pattern preferably centered about a dimple, and having a plurality, namely five (5), radially extending arms extending outward from the center of the pattern or dimple. The sides of each radially extending arm intersect with the sides of adjacent radially extending arms. The distal end of each radially extending arm is preferably rounded. The golf ball **30** further comprises a second visible star-shaped perimeter weighting system pattern located on the opposite side of the ball **30**. This second pattern is most preferably directly opposite from the first pattern and is of equal size and mass as the first pattern. These considerations are described in greater detail below.

FIG. 4 is an elevational view of a preferred embodiment golf ball **40** in accordance with the present invention utilizing a contoured-shaped perimeter weighting system **42**. This system comprises patterns similar to the star-shaped pattern depicted in FIG. 3 except that generally continuous arcuate sections extend between and connect the sides of adjacent radially extending arms. The golf ball **40** further comprises a second visible contoured-shaped perimeter weighting system pattern located on the opposite side of the ball **40**. This second pattern is most preferably directly opposite from the first pattern and is of equal size and mass as the first pattern.

FIG. 5 is a partial cross-sectional view of a region of weighting material **32** illustrated in FIG. 3. FIG. 5 shows an arrangement in which the inner layer **14** containing weighting material extends radially outward through the golf ball outer cover so that it is visible along the exterior surface of the ball.

FIG. 6 is a partial cross-sectional view of a region of weighting material **32** illustrated in FIG. 3. FIG. 6 shows an alternate arrangement in which weighting material is only present within the visible region and is generally not present within the inner layer **15** beyond the visible region. Although FIG. 6 shows the weighting material radially extending into and through the inner cover layer **14**, the present invention encompasses golf ball configurations in which the weighting material does not extend into the inner cover layer **14** extending under the visible weighted region.

FIG. 7 illustrates a preferred embodiment golf ball **50** in accordance with the present invention utilizing a pentagon-shaped perimeter weighting system **52**. It can be seen that the pentagon shape is symmetrically disposed about a center dimple and five (5) adjacent or surrounding dimples. Additionally, each side of the pentagon is slightly curved inward so as to not extend over a neighboring dimple. The golf ball **50** further comprises a second visible pentagon-shaped perimeter weighting system pattern located on the opposite side of the ball **50**. The second pattern is most preferably directly opposite from the first pattern and is of equal size and mass as the first pattern.

FIG. 8 illustrates a preferred embodiment golf ball **60** in accordance with the present invention utilizing a visible radiused pentagon-shaped perimeter weighting system **62**. This pattern is also symmetrically disposed over a center dimple and the five (5) perimeter dimples, like the pentagon pattern depicted in FIG. 7. This pattern of the system **62** also extends over an additional five (5) dimples. The golf ball **60** further comprises a second visible radiused pentagon-shaped perimeter weighting system pattern located on the opposite side of the ball **60**. The second pattern is most preferably directly opposite from the first pattern and is of equal size and mass as the first pattern.

FIG. 9 is an elevational view of a preferred embodiment golf ball 70 in accordance with the present invention utilizing a visible single stripe perimeter weighting system 72. It can be seen in FIG. 9 that the stripe is approximately slightly larger in width than the diameter of a typical dimple on the golf ball 70. The stripe preferably extends around the circumference of the ball 70.

FIG. 10 illustrates a preferred embodiment golf ball 80 in accordance with the present invention utilizing a double striped perimeter weighting system 82. It can be seen that the stripes preferably intersect one another at right angles, and that the width of each stripe is approximately only slightly greater than the diameter of a typical dimple on the ball 80. Each stripe preferably extends around the circumference of the ball 80. It is also preferred that the stripes are equal in width, or approximately so.

FIG. 11 is an elevational view of a preferred embodiment golf ball 90 in accordance with the present invention utilizing a multi-stripe perimeter weighting system 92. As shown in FIG. 11, the multi stripe perimeter weighting system 92 comprises preferably four (4) stripes, intersecting one another at a common point of intersection. Again, the width of each stripe is preferably approximately slightly greater than the diameter of a typical dimple on the ball 90. And, the stripes are of equal width. Each stripe preferably extends around the circumference of the ball 90.

FIG. 12 illustrates a preferred embodiment golf ball 100 in accordance with the present invention utilizing a visible stripe and dimple perimeter weighting system. The system comprises a plurality of stripes 104 and a plurality of dimples 102. Each of the stripes preferably extends around the circumference of the ball 100. Most preferably, the system comprises two (2) intersecting stripes 104, disposed at right angles to one another, and a total of eight (8) dimples 102 as shown in FIG. 12. It will be understood that the other four (4) weighted dimples 102 are located on the other side of the ball 100. The stripes preferably are of equal width.

FIG. 13 illustrates a preferred embodiment golf ball 110 in accordance with the present invention utilizing a ring-shaped perimeter weighting system as shown in FIG. 13. The system comprises a plurality of rings 114 and 116 and a center weighted dimple or spot 118. Preferably, the rings 114 and 116 are concentrically arranged about the center spot 118. Two (2) identical concentrically arranged rings are located on the other side of the ball 110. Most preferably, these rings are directly opposite from the rings 114 and 116, and are of equivalent size and mass as the rings 114 and 116.

FIG. 14 is an elevational view of a preferred embodiment golf ball 120 in accordance with the present invention utilizing a first spiral-shaped perimeter weighting system 122. It will be understood that an identical second spiral-shaped pattern is located on the other side of the ball 120. Most preferably, the second spiral pattern is of equivalent size and mass as the first pattern and is directly opposite from the first pattern.

FIG. 15 is a partial cross-sectional view of a preferred embodiment golf ball in accordance with the present invention illustrating a transparent, or generally so, viewing window in accordance with the present invention. The preferred embodiment golf ball 130 comprises an intermediate golf ball, such as a core assembly, core and mantle, or core and one or more inner cover layers, denoted in FIG. 15 as 138. FIG. 15 further illustrates an interior layer 136 and serving as an outermost layer, cover layer 132. Defined within the outer layer 132 is a viewing window 134. Viewing window 134 is defined by a border 135 as shown in FIG. 15.

FIG. 16 illustrates another preferred embodiment in accordance with the present invention for a golf ball having a viewing window. FIG. 16 illustrates a golf ball 140 comprising an intermediate ball 148, an inner layer 146, and an outer layer 142. Defined within a region of the inner layer 146 is a weighted region 147 defined by border 149. Defined along the exterior surface of the ball is a viewing window 144 defined by a border 145. It will be appreciated that the borders 145 and 149 generally overlie one another so that the viewing window is approximately the same size and configuration as the region of weighting material 147 disposed radially inward of the viewing window 144.

FIG. 17 illustrates another preferred embodiment golf ball 150 in accordance with the present invention. The golf ball 150 comprises an intermediate ball 158 having an inner layer of 156 comprising weighting material and an outer layer 152. A viewing window 154 is defined by a border 155 located in the outer layer 152. It will be appreciated that although the inner layer 156 contains weighting material throughout its entirety, and thus does not contain a discrete region of weighting material as in the embodiment 140 shown in FIG. 16, the appearance of the weighted regions of the preferred embodiments 140 and 150 will be the same along the exterior of the ball.

FIG. 18 illustrates another preferred embodiment golf ball in accordance with the present invention. This preferred embodiment ball comprises an intermediate ball 168, an inner layer 166 disposed thereon, and an outer layer 162. A region of weighting material 167 is disposed generally along the inner layer 166 and defined by border 169. A viewing window 164 is provided along the outer layer 162, the configuration of which is defined by border 165. It will be appreciated that the border 169 is offset from the border 165 such that the region of weighting material 167 is generally larger than the region of the viewing window 164. Although the borders 169 and 165 do not overlie one another, the general appearance of the weighted region will approximate that of the regions in the preferred embodiments 140 and 150 illustrated in FIGS. 16 and 17, respectively.

It will be understood that in all of the foregoing preferred embodiments, it is particularly preferred that the center of mass of the weighted ball coincides with the geometrical center of the ball, i.e., its centerpoint. This is the primary reason for providing a second identical pattern of weighting material on an opposite side from a first pattern. If a single pattern of weighting material is provided on only one side of a ball, the resulting center of mass of the ball will be offset from the ball's centerpoint. It may also be preferable to utilize one or more coloring or pigmented agents dispersed within the weighting material to provide desired coloring to the weighted region.

It will also be understood that the viewing window is transparent or generally so. At a minimum, the viewing window is translucent to at least allow the passage of light rays therethrough. The viewing window must be sufficiently translucent to enable, at least a portion of, the weighting material or other material disposed under, e.g. radially inward of, the viewing window to be seen therethrough. In some preferred embodiments according to the present invention, the viewing window is one or more generally transparent portions of an outer cover layer while the remaining portions of that outer cover layer are generally opaque and do not allow the passage of light therethrough.

In accordance with many of the preferred embodiments of the present invention, the various recessed regions and viewing windows incorporated in many of the golf balls

described herein generally constitute only a portion of the outer surface area of the golf ball. This significant aspect distinguishes the preferred embodiment golf balls from prior art golf balls having transparent cover layers. Moreover, prior artisans took efforts to hide or cover up weighting materials that may have been incorporated in prior art golf balls. A significant feature of the present invention is the revealing or exposure of weighting material in a golf ball, so that such material, disposed internally within the ball, may be seen by the consumer or user of the ball.

In preparing golf balls in accordance with the present invention, a hard, relatively heavy, inner cover layer is molded (by injection molding or by compression molding) about a relatively light core (preferably a lighter and smaller solid core). A comparatively softer outer cover layer is molded over the inner cover layer.

The core (preferably a solid core) is about 1.28 inches to 1.570 inches in diameter, preferably about 1.37 to about 1.54 inches, and most preferably 1.42 inches. The cores weigh about 18 to 39 grams, desirably 25 to 30, and most preferably 29.7–29.8 grams.

The solid cores are typically compression molded from a slug of uncured or lightly cured elastomer composition comprising a high cis content polybutadiene and a metal salt of an  $\alpha$ ,  $\beta$ , ethylenically unsaturated carboxylic acid such as zinc mono or diacrylate or methacrylate. To achieve higher coefficients of restitution in the core, the manufacturer may include fillers such as small amounts of a metal oxide such as zinc oxide. In addition, lesser amounts of metal oxide can be included in order to lighten the core weight so that the finished ball more closely approaches the U.S.G.A. upper weight limit of 1.620 ounces. Other materials may be used in the core composition including compatible rubbers or ionomers, and low molecular weight fatty acids such as stearic acid. Free radical initiators such as peroxides are admixed with the core composition so that on the application of heat and pressure, a complex curing cross-linking reaction takes place.

It will be understood that a wide array of other core configurations and materials could be utilized in conjunction with the present invention. For example, cores disclosed in U.S. Pat. Nos. 5,645,597; 5,480,155; 5,387,637; 5,150,906; 5,588,924; 5,507,493; 5,503,397; 5,482,286; 5,018,740; 4,852,884; 4,844,471; 4,838,556; 4,726,590; and 4,650,193; all of which are hereby incorporated by reference, may be utilized in whole or in part.

The specially produced core compositions and resulting molded cores of the present invention are manufactured using relatively conventional techniques. In this regard, the core compositions of the invention may be based on polybutadiene, and mixtures of polybutadiene with other elastomers. It is preferred that the base elastomer have a relatively high molecular weight. The broad range for the molecular weight of suitable base elastomers is from about 50,000 to about 500,000. A more preferred range for the molecular weight of the base elastomer is from about 100,000 to about 500,000. As a base elastomer for the core composition, cis-polybutadiene is preferably employed, or a blend of cis-polybutadiene with other elastomers may also be utilized. Most preferably, cis-polybutadiene having a weight-average molecular weight of from about 100,000 to about 500,000 is employed. Along this line, it has been found that the high cis-polybutadiene manufactured and sold by Shell Chemical Co., Houston, Tex., under the tradename Cariflex BR-1220, the high cis-polybutadiene sold by Bayer Corp. under the designation Taktene 220, and the polyiso-

prene available from Muehlstein, H & Co., Greenwich, Conn. under the designation "SKI 35" are particularly well suited.

The unsaturated carboxylic acid component of the core composition (a co-crosslinking agent) is the reaction product of the selected carboxylic acid or acids and an oxide or carbonate of a metal such as zinc, magnesium, barium, calcium, lithium, sodium, potassium, cadmium, lead, tin, and the like. Preferably, the oxides of polyvalent metals such as zinc, magnesium and cadmium are used, and most preferably, the oxide is zinc oxide.

Exemplary of the unsaturated carboxylic acids which find utility in the present core compositions are acrylic acid, methacrylic acid, itaconic acid, crotonic acid, sorbic acid, and the like, and mixtures thereof. Preferably, the acid component is either acrylic or methacrylic acid. Usually, from about 15 to about 25, and preferably from about 17 to about 21 parts by weight of the carboxylic acid salt, such as zinc diacrylate, is included in the core composition. The unsaturated carboxylic acids and metal salts thereof are generally soluble in the elastomeric base, or are readily dispersible.

The free radical initiator included in the core composition is any known polymerization initiator (a co-crosslinking agent) which decomposes during the cure cycle. The term "free radical initiator" as used herein refers to a chemical which, when added to a mixture of the elastomeric blend and a metal salt of an unsaturated, carboxylic acid, promotes crosslinking of the elastomers by the metal salt of the unsaturated carboxylic acid. The amount of the selected initiator present is dictated only by the requirements of catalytic activity as a polymerization initiator. Suitable initiators include peroxides, persulfates, azo compounds and hydrazides. Peroxides which are readily commercially available are conveniently used in the present invention, generally in amounts of from about 0.1 to about 10.0 and preferably in amounts of from about 0.3 to about 3.0 parts by weight per each 100 parts of elastomer.

Exemplary of suitable peroxides for the purposes of the present invention are dicumyl peroxide, n-butyl 4,4'-bis (butylperoxy) valerate, 1,1-bis(t-butylperoxy)-3,3,5-trimethyl cyclohexane, di-t-butyl peroxide and 2,5-di-(t-butylperoxy)-2,5dimethyl hexane and the like, as well as mixtures thereof. It will be understood that the total amount of initiators used will vary depending on the specific end product desired and the particular initiators employed.

Examples of such commercially available peroxides are Luperco 230 or 231 XL sold by Atochem, Lucidol Division, Buffalo, N.Y., and Trigonox 17/40 or 29/40 sold by Akzo Chemie America, Chicago, Ill. In this regard Luperco 230 XL and Trigonox 17/40 are comprised of n-butyl 4,4-bis (butylperoxy) valerate; and, Luperco 231 XL and Trigonox 29/40 are comprised of 1,1-bis(t-butylperoxy)-3,3,5-trimethyl cyclohexane. The one hour half life of Luperco 231 XL is about 112° C., and the one hour half life of Trigonox 29/40 is about 129° C.

The core compositions of the present invention may additionally contain any other suitable and compatible modifying ingredients including, but not limited to, metal oxides, fatty acids, and diisocyanates and polypropylene powder resin. For example, Papi 94, a polymeric diisocyanate, commonly available from Dow Chemical Co., Midland, Mich., is an optional component in the rubber compositions. It can range from about 0 to 5 parts by weight per 100 parts by weight rubber (phr) component, and acts as a moisture scavenger. In addition, it has been found that the addition of

a polypropylene powder resin results in a core which is too hard (i.e. exhibits low compression) and thus allows for a reduction in the amount of crosslinking agent utilized to soften the core to a normal or below normal compression.

Furthermore, because polypropylene powder resin can be added to core composition without an increase in weight of the molded core upon curing, the addition of the polypropylene powder allows for the addition of higher specific gravity fillers (if desired), such as mineral fillers. Since the crosslinking agents utilized in the polybutadiene core compositions are expensive and/or the higher specific gravity fillers are relatively inexpensive, the addition of the polypropylene powder resin substantially lowers the cost of the golf ball cores while maintaining, or lowering, weight and compression.

The polypropylene (C<sub>3</sub>H<sub>5</sub>) powder suitable for use in the present invention has a specific gravity of about 0.90 g/cm<sup>3</sup>, a melt flow rate of about 4 to about 12 and a particle size distribution of greater than 99% through a 20 mesh screen. Examples of such polypropylene powder resins include those sold by the Amoco Chemical Co., Chicago, Ill., under the designations "6400 P", "7000 P" and "7200 P". Generally, from 0 to about 25 parts by weight polypropylene powder per each 100 parts of elastomer are included in the present invention.

Various activators may also be included in the compositions of the present invention. For example, zinc oxide and/or magnesium oxide are activators for the polybutadiene. The activator can range from about 2 to about 50 parts by weight per 100 parts by weight of the rubbers (phr) component. The amount of activation utilized can be reduced in order to lighten the weight of the core.

Moreover, reinforcement agents may be added to the composition of the present invention. As noted above, the specific gravity of polypropylene powder is very low, and when compounded, the polypropylene powder produces a lighter molded core. Further, when a lesser amount of activation is used, the core is also lighter. As a result, if necessary, higher gravity fillers may be added to the core composition so long as the specific core weight limitations are met. The amount of additional filler included in the core composition is primarily dictated by weight restrictions and preferably is included in amounts of from about 0 to about 100 parts by weight per 100 parts rubber.

Exemplary fillers include mineral fillers such as limestone, silica, mica, barytes, calcium carbonate, or clays. Limestone is ground calcium/magnesium carbonate and is used because it is an inexpensive, heavy filler.

As indicated, ground flash filler may be incorporated and is preferably 20 mesh ground up center stock from the excess flash from compression molding. It lowers the cost and may increase the hardness of the ball.

Fatty acids or metallic salts of fatty acids may also be included in the compositions, functioning to improve moldability and processing. Generally, free fatty acids having from about 10 to about 40 carbon atoms, and preferably having from about 15 to about 20 carbon atoms, are used. Exemplary of suitable fatty acids are stearic acid and linoleic acids, as well as mixtures thereof. Exemplary of suitable metallic salts of fatty acids include zinc stearate. When included in the core compositions, the fatty acid component is present in amounts of from about 1 to about 25, preferably in amounts from about 2 to about 15 parts by weight based on 100 parts rubber (elastomer).

Diisocyanates may also be optionally included in the core compositions when utilized, the diisocyanates are included

in amounts of from about 0.2 to about 5.0 parts by weight based on 100 parts rubber. Exemplary of suitable diisocyanates is 4,4'-diphenylmethane diisocyanate and other polyfunctional isocyanates know to the art.

Furthermore, the dialkyl tin difatty acids set forth in U.S. Pat. No. 4,844,471, the dispersing agents disclosed in U.S. Pat. No. 4,838,556, and the dithiocarbamates set forth in U.S. Pat. No. 4,852,884 may also be incorporated into the polybutadiene compositions of the present invention. The specific types and amounts of such additives are set forth in the above identified patents, which are incorporated herein by reference.

The core compositions of the invention are generally comprised of 100 parts by weight of a base elastomer (or rubber) selected from polybutadiene and mixtures of polybutadiene with other elastomers, 10 to 40 parts by weight of at least one metallic salt of an unsaturated carboxylic acid, and 1 to 10 parts by weight of a free radical initiator.

As indicated above, additional suitable and compatible modifying agents such as particulate polypropylene resin, fatty acids, and secondary additives such as Pecan shell flour, ground flash (i.e. grindings from previously manufactured cores of substantially identical construction), barium sulfate, zinc oxide, etc. may be added to the core compositions to adjust the weight of the ball as necessary in order to have the finished molded ball (core, cover and coatings) to closely approach the U.S.G.A. weight limit of 1.620 ounces.

In producing golf ball cores utilizing the present compositions, the ingredients may be intimately mixed using, for example, two roll mills or a Banbury® mixer until the composition is uniform, usually over a period of from about 5 to about 20 minutes. The sequence of addition of components is not critical. A preferred blending sequence is as follows.

The elastomer, polypropylene powder resin (if desired), fillers, zinc salt, metal oxide, fatty acid, and the metallic dithiocarbamate (if desired), surfactant (if desired), and tin difatty acid (if desired), are blended for about 7 minutes in an internal mixer such as a Banbury® mixer. As a result of shear during mixing, the temperature rises to about 200° F. The initiator and diisocyanate are then added and the mixing continued until the temperature reaches about 220° F. whereupon the batch is discharged onto a two roll mill, mixed for about one minute and sheeted out.

The sheet is rolled into a "pig" and then placed in a Barwell preformer and slugs are produced. The slugs are then subjected to compression molding at about 320° F. for about 14 minutes. After molding, the molded cores are cooled, the cooling effected at room temperature for about 4 hours or in cold water for about one hour. The molded cores are subjected to a centerless grinding operation whereby a thin layer of the molded core is removed to produce a round core having a diameter of 1.28 to 1.570 inches (preferably about 1.37 to about 1.54 inches and most preferably, 1.42 inches). Alternatively, the cores are used in the as-molded state with no grinding needed to achieve roundness.

The mixing is desirably conducted in such a manner that the composition does not reach incipient polymerization temperatures during the blending of the various components.

Usually the curable component of the composition will be cured by heating the composition at elevated temperatures on the order of from about 275° F. to about 350° F., preferably and usually from about 290° F. to about 325° F., with molding of the composition effected simultaneously with the curing thereof. The composition can be formed into a core structure by any one of a variety of molding

techniques, e.g. injection, compression, or transfer molding. When the composition is cured by heating, the time required for heating will normally be short, generally from about 10 to about 20 minutes, depending upon the particular curing agent used. Those of ordinary skill in the art relating to free radical curing agents for polymers are conversant with adjustments of cure times and temperatures required to effect optimum results with any specific free radical agent.

After molding, the core is removed from the mold and the surface thereof, preferably treated to facilitate adhesion thereof to the covering materials. Surface treatment can be effected by any of the several techniques known in the art, such as corona discharge, ozone treatment, sand blasting, and the like. Preferably, surface treatment is effected by grinding with an abrasive wheel.

The relatively thick inner cover layer which is molded over the core is about 0.200 inches to about 0.055 inches in thickness, and preferably about 0.075 inches thick. The outer cover layer is about 0.010 inches to about 0.110 inches in thickness, and preferably 0.055 inches thick. A preferred range for the overall thickness of these layers is from about 0.050 inches to about 0.300 inches, more preferably from about 0.075 inches to about 0.250 inches, and most preferably from about 0.100 inches to about 0.200 inches. Individually, each layer may be as thin as about 0.010 inches and as thick as about 0.200 inches where one layer is weighted, or contains weighting material. Together, the core, the inner cover layer and the outer cover layer combine to form a ball having a diameter of 1.680 inches or more, the minimum diameter permitted by the rules of the United States Golf Association and weighing no more than 1.620 ounces.

The various cover composition layers of the present invention may be produced according to conventional melt blending procedures. In the case of the outer cover layer, when a blend of hard and soft, low acid ionomer resins are utilized, the hard ionomer resins are blended with the soft ionomeric resins and with a masterbatch containing the desired additives in a Banbury® mixer, two-roll mill, or extruder prior to molding. The blended composition is then formed into slabs and maintained in such a state until molding is desired. Alternatively, a simple dry blend of the pelletized or granulated resins and color masterbatch may be prepared and fed directly into the injection molding machine where homogenization occurs in the mixing section of the barrel prior to injection into the mold. If necessary, further additives, may be added and uniformly mixed before initiation of the molding process. A similar process is utilized to formulate the ionomer resin compositions used to produce the inner cover layer. The metal particles are added and mixed prior to initiation of molding.

Golf balls comprising the preferred embodiment visible perimeter weighting system can be formed according to the teachings herein. A wide array of techniques can be utilized to incorporate relatively high density weighting material into or along the outer periphery of a golf ball, and preferably such that the material is deposited or formed into a desired pattern, and most preferably, such that the weighting material is visible from the ball's exterior.

Preferably, the desired pattern of weighting material is molded along the outer periphery of the golf ball as a radially extending portion of the inner cover or mantle layer. That is, the pattern is molded with the mantle layer such that the pattern extends radially outward to the final radius of the ball, or substantially so, and the non-weighted white cover is subsequently molded about the pattern of weighting material.

Although this is a preferred method, it is also contemplated that a plug manufacturing technique could be utilized. In that technique, plugs of the desired pattern of weighting material are incorporated into the outer periphery of the ball to form the visible weighting system.

Yet another preferred technique for forming a perimeter weighting pattern along the outer periphery of a golf ball is to incorporate the weighting material into the inner layer or mantle of the ball and deposit or otherwise dispose one or more layers of a transparent or semi-transparent material over the pattern of weighting material disposed in the ball.

FIGS. 19 and 20 illustrate two particularly preferred methods for forming weighted perimeter golf balls having viewing windows formed along their exterior, through which weighting material is visible. FIG. 19 is a schematic block diagram for techniques in which a viewing window, either preformed or molded in-situ, is deposited or formed along the exterior of a golf ball prior to molding of the cover layer. FIG. 20 is schematic block diagram for techniques in which a viewing window, either preformed or molded in-situ, is deposited along the ball exterior, within a void or recessed region, subsequent to molding of the cover layer.

Specifically, the technique of FIG. 19 first involves providing an intermediate golf ball. Such an intermediate component may include a core assembly, core and mantle, or core and one or more inner cover layers. Next, a preformed viewing window is provided and positioned and secured along the surface of the intermediate ball. Alternatively, the viewing window may be molded along the outer surface of the intermediate ball in the desired shape and configuration. After having formed or otherwise deposited the viewing window along the exterior of the intermediate golf ball, one or more cover layers are molded about the viewing window. The resulting ball is then subjected to desired finishing operations.

FIG. 20 illustrates a technique in which a similar intermediate golf ball is provided. A window insert is then provided and temporarily secured along the outer surface of the intermediate ball. The window insert is essentially a void-forming molding component, that when temporarily affixed to the intermediate ball and a cover molded thereon, produces a void or recessed region for receiving a viewing window.

Once the window insert is appropriately secured along the ball exterior, the desired cover layer is molded about the ball and window insert. Next, the window insert is removed thereby leaving a void or recessed region. A viewing window may then be molded in-situ in the void or region. As will be appreciated, an effective amount of material to form the viewing window is deposited into the void or recessed region, and then molded therein to form the viewing window. Alternatively, a preformed window may be positioned within the void or recess and affixed therein. The resulting golf ball is then subjected to the desired finishing operations.

In all of the foregoing techniques, the incorporation of weighting material in a particular pattern is utilized to increase the moment of inertia of the ball. This results in increasing the travel distance of the ball by decreasing initial spin rates, yet maintaining playability of the ball by increasing terminal spin rates. That is, incorporation of patterns of weighting material in a golf ball decreases the spin decay of the ball from the point of impact to the time at which the ball is at rest.

Moreover, it is also within the scope of the present invention to provide a perimeter weighting system in a golf ball by utilizing a single layer, such as a cover layer, that

comprises discontinuous areas of distinct materials, i.e., materials having different densities.

The golf balls of the present invention can be produced by molding processes currently well known in the golf ball art. Specifically, the golf balls can be produced by injection molding or compression molding the relatively thick inner cover layer about smaller and lighter wound or solid molded cores to produce an intermediate golf ball having a diameter of about 1.38 to 1.68 inches, more preferably about 1.50 to 1.67 inches, and most preferably about 1.57 inches. The outer layer (preferably 0.010 inches to 0.110 inches in thickness) is subsequently molded over the inner layer to produce a golf ball having a diameter of 1.680 inches or more. Although either solid cores or wound cores can be used in the present invention so long as the size weight and other physical perimeters are met, as a result of their lower cost and superior performance, solid molded cores are preferred over wound cores.

In compression molding, the inner cover composition is formed via injection at about 380° F. to about 450° F. into smooth surfaced hemispherical shells which are then positioned around the core in a mold having the desired inner cover thickness and subjected to compression molding at 200° F. to 300° F. for about 2 to 10 minutes, followed by cooling at 50° F. to 70° F. for about 2 to 7 minutes to fuse the shells together to form a unitary intermediate ball. In addition, the intermediate balls may be produced by injection molding wherein the inner cover layer is injected directly around the core placed at the center of an intermediate ball mold for a period of time in a mold temperature of from 50° F. to about 100° F. Subsequently, the outer cover layer is molded about the core and the inner layer by similar compression or injection molding techniques to form a dimpled golf ball of a diameter of 1.680 inches or more. After molding, the golf balls produced may undergo various further processing steps such as buffing, painting and marking as disclosed in U.S. Pat. No. 4,911,451.

The finished golf ball of the present invention possesses the following general features:

A) Core (preferably a solid core)

- 1) Weight, from about 18 to 39 grams, preferably, 25 to 30 grams, most preferably 29.7–29.8 grams.
- 2) Size (diameter), from about 1.28 to 1.57 inches, preferably, 1.37 to 1.54 inches, most preferably 1.42 inches.
- 3) Specific gravity, from about 1.05 to 1.30, preferably 1.10 to 1.25, most preferably 1.2.
- 4) Compression (Riehle), from about 60 to about 170, preferably 110 to 140, most preferably 117 to 124.
- 5) Coefficient of Restitution (C.O.R.), from about 0.700 to about 0.800, preferably 0.740 to 0.780, most preferably 0.765 to 0.770.

B) Inner Cover Layer (Mantle) and Core

- 1) Weight, from about 25.9 to 43.0 grams, preferably, 29 to 40 grams, most preferably 38.4 grams.
- 2) Size (diameter), from about 1.38 to 1.68 inches, preferably, 1.50 to 1.67 inches, most preferably 1.57 inches.
- 3) Thickness of inner cover layer, from about 0.010 to about 0.200 inches, preferably 0.055 to 0.150, most preferably 0.075 inches.
- 4) Specific gravity (inner cover layer only), from about 0.96 to 1.80, preferably 1.00 to 1.30, most preferably 1.05.
- 5) Compression (Riehle), from about 59 to about 169, preferably 80 to 96, most preferably 84–92.

6) Coefficient of Restitution (C.O.R.), from about 0.701 to about 0.820, preferably 0.750 to 0.810, most preferably 0.790 to 0.800.

7) Shore C/D Hardness, from about 87/60 to about 100/100, preferably 92/65 to 100/85, most preferably 97/70.

C. Outer Cover Layer, Inner Cover Layer and Core

- 1) Weight, from about 45.0 to 45.93 grams, preferably, 45.3 to 45.7 grams, most preferably 45.5 grams.
- 2) Size (diameter), from about 1.680 to 1.720 inches, preferably, 1.680 to 1.700 inches, most preferably 1.68 inches.
- 3) Cover Thickness (outer cover layer), from about 0.010 to about 0.175 inches, preferably 0.010 to 0.110, most preferably 0.055 inches.
- 4) Compression (Riehle), from about 59 to about 160, preferably 80 to 96, most preferably 76–85.
- 5) Coefficient of Restitution (C.O.R.), from about 0.701 to about 0.825, preferably 0.750 to 0.810, most preferably 0.785 to 0.790.
- 6) Shore C/D Hardness, from about 35/20 to about 92/65, preferably 40/25 to 90/60, most preferably 87/56.
- 7) Moment of Inertia, from about 0.390 to about 0.480, preferably 0.430 to 0.460, most preferably 0.445.

The most preferred characteristic noted above are included in Applicant's commercialized "Strata Advance" balls. These balls ("Strata Advance 90" and "Strata Advance 100") contain smaller and lighter cores and heavier and thicker thermoplastic inner cover layers. The enhanced weight in the inner cover layer is produced, in part, through the inclusion of 10 phr of powdered brass. The displacement of weight from the core to the inner cover layer produces a golf ball with a greater moment of inertia, reduced spin and longer travel distance without affecting the balls' feel and durability characteristics. The components and physical properties of these balls are shown below in Table 14.

TABLE 14

Formulations	CORE				
	Advance 90	Advance 100	Range		
Cariflex 1220 (High Cis-polybutadiene)	70	70			
Taktene 220 (High Cis-polybutadiene)	30	30			
Zinc Oxide	31	30.5			
TG Regrind (Core regrind)	20	20			
Zinc Diacrylate	17.5	18.5			
Zinc Stearate	15	15			
231 XL Peroxide	0.9	0.9			
<u>Core Data</u>					
Size	1.42"	1.42"	+/-0.003		
Weight (grams)	29.7	29.7	+/-0.3		
Comp (Riehle)	124	117	+/-5		
C.O.R.	.765	.770	+/-0.015		
Spec. Grav.	1.2	1.2			
Formulations	MANTLE				
	Mod- ulus	Spec. Grav.	Distance 90	Distance 100	Range
Iotek 1002	380 MPa	0.95	45	45	
Iotek 1003	147 MPa	0.95	45	45	
Powdered Brass	—	8.5	10	10	

TABLE 14-continued

Blend Modulus (Estimated)	264 MPa	264 MPa	
Spec. Grav. Blend	1.05	1.05	
<u>Mantle Data</u>			
Size	1.57"	1.57"	+/-0.003
Thickness	0.075"	0.075"	+/-0.003
Weight (grams)	38.4	38.4	+/-0.3
Comp (Riehle)	92	84	+/-4
COR	.795	.800	+/-0.015
Shore C/D	97/70	97/70	+/-1
<u>COVER</u>			
Formulations	Modulus	Advance 90	Advance 100 Range
Iotek 7510	35 MPa	58.9	58.9
Iotek 8000	320 MPa	33.8	33.8
Iotek 7030	155 MPa	7.3	7.3
Blend Modulus (Estimated)		140 MPa	140 MPa
Spec. Grav. Blend		0.98	0.98
<u>Whitener Package</u>			
Unitane 0-110 <sup>1</sup>		2.3 phr	2.3 phr
Eastobrite OB-1 <sup>2</sup>		0.025 phr	0.025 phr
Ultra Marine Blue <sup>3</sup>		0.042 phr	0.042 phr
Santonox R <sup>4</sup>		0.004 phr	0.004 phr
<u>Ball Data</u>			
Size		1.68"	1.68"
Cover Thickness		0.055"	0.055"
Weight (grams)		45.5	45.5
Comp (Riehle)		80	76
C.O.R.		.785	.790
Shore C/D		87/56	87/56
Moment of Inertia		0.445	0.445

<sup>1</sup>Kemira Pigments Inc, Savannah, GA

<sup>2</sup>Eastmanchemicals, Kingsport, TX

<sup>3</sup>Whittaker, Clark, & Daniels Inc., Plainfield, NJ

<sup>4</sup>Monsanto Co., St. Louis, MO

With respect to Applicant's currently available multi-layer golf balls (i.e., "Strata Tour"), the cores of the new balls are substantially smaller (1.42" versus 1.47") and lighter (29.7 grams versus 32.7 grams) have thicker (i.e., 0.075" versus 0.050") and heavier (8.7 grams versus 5.7 grams) inner cover layers. The balls of the present invention produce lower spin and greater distance in comparison with the existing multi-layer golf balls. The difference in physical properties is shown in the table which follows in Table 15:

TABLE 15

	Strata 100	Strata 90
<u>Core Data</u>		
Size	1.47"	1.47"
Weight	32.7 g	32.7 g
Comp (Riehle)	99	106
C.O.R.	.770-.795	.765-.795
Specific Gravity	1.209	1.209
Hardness (Shore C)	74-78	78-81
<u>Mantle or Inner Layer Data</u>		
Size	1.57	1.57
Weight	38.4 g	38.4 g
Comp (Riehle)	85	85
C.O.R.	.795-.810	.795-.810
Thickness	0.050"	0.050"
Hardness (Shore C/D)	97/70	97/70
Specific Gravity	0.95	0.95

TABLE 15-continued

	Strata 100	Strata 90
<u>Outer Layer Data</u>		
Cover Hardness (Shore C/D)	78/47	70/47
Thickness	0.055"	0.055"
Specific Gravity	0.97	0.97
<u>Final Ball Data</u>		
Size	1.68"	1.68"
Weight	45.4 g	45.4 g
Comp (Riehle)	76	81
C.O.R.	785-.810	.783-.810

The resulting golf balls of the present invention (i.e., the "Strata Advance" balls) provide for desirable coefficient of restitution, compression, and durability properties while at the same time offering the feel characteristics associated with soft balata and balata-like covers of the prior art. In addition, the balls spin less and travel farther.

The present invention is further illustrated by the following examples in which the parts of the specific ingredients are by weight. It is to be understood that the present invention is not limited to the examples, and various changes and modifications may be made in the invention without departing from the spirit and scope thereof.

EXAMPLE 1

A number of multi-layer golf balls (solid cores plus inner and outer cover layers) containing metallic particles and/or heavy weight filler additives in the inner cover layer were prepared according to the procedures described above. The moment of inertia (g/cm<sup>2</sup>) of these balls were compared with commercially available two piece, three piece and other multi-layered balls. The results are set forth in the tables below.

The cores of the golf balls used in this Example ranged in diameter from 1.42 to 1.47 inches, weighed 26.1 to 32.5 grams, and had a specific gravity of 1.073 to 1.216. These cores were comprised of high cis-polybutadiene, zinc diacrylate, zinc oxide, zinc stearate, peroxide, etc. and were produced according to molding procedures set forth above. Representative formulations of the molded cores (1.42 inches and 1.47 inches) are set forth below in Sample Nos. 20-23 for 1.42 inch cores and Sample No. 23 for 1.47 inch cores.

The above cores exhibited the following general characteristics as set forth in Table 16:

TABLE 16

	For Samples No.s 1 to 16	For Samples No.s 17 to 19
Size	1.47"	1.47"
Weight (grams)	32.7	32.7
Comp (Riehle)	100	99
Spec. Grav.	1.209	.761
C.O.R.	.763	

The inner thermoplastic cover layer (or mantle layer) used in this Example comprised a 50%/50% blend of ethylene acrylic acid ionomer resins, i.e., lotek 1002 and lotek 1003. These ionomers exhibit the characteristics generally defined above.

A series of golf balls were formulated with inner cover layers containing 5 phr of various metal particles or heavy weight fillers and 47.5% lotek 1002 and 47.5% lotek 1003.



Two (2) control balls were also produced (Sample Nos. 14 and 15 below) containing no fillers (i.e., 50% Iotek 1002 and 50% Iotek 1003). The general properties of the balls were measured according to the following perimeters:

Riehle compression is a measurement of the deformation of a golf ball in thousandths of inches under a fixed static load of 200 pounds (a Riehle compression of 47 corresponds to a deflection under load of 0.047 inches).

PGA compression is determined by a force applied to a spring (i.e., 80 PGA=80 Riehle; 90 PGA=70 Riehle;

and 100 PGA=60 Riehle) and manufactured by OK Automation, Sinking Spring, Pa. 19608.

Coefficient of restitution (C.O.R.) was measured by firing the resulting golf ball in an air cannon at a velocity of 125 feet per second against a steel plate which is positioned 12 feet from the muzzle of the cannon. The rebound velocity was then measured. The rebound velocity was divided by the forward velocity to give the coefficient of restitution.

The following properties were noted and set forth in Table 17:

TABLE 17

Sample No.	Additive to Mantle	SIZE		WEIGHT		COMP. (RIEHLE)		C.O.R.	
		Center & Mantle	Molded Cover	Center & Mantle	Molded Cover	Center & Mantle	Molded Cover	Center & Mantle	Molded Cover
1	Bismuth Powder	1.573	1.686	38.8	45.89	84	79	0.7921	0.7765
2	Boron Powder	1.574	1.686	38.8	45.79	83	79	0.7943	0.7754
3	Brass Powder	1.575	1.686	38.9	45.9	84	80	0.7944	0.7757
4	Bronze Powder	1.573	1.686	38.8	45.89	84	80	0.7936	0.7770
5	Cobalt Powder	1.573	1.686	38.9	45.88	82	79	0.7948	0.7775
6	Copper Powder	1.574	1.686	38.9	45.9	84	80	0.7932	0.7762
7	Inconel Metal Powder	1.574	1.687	39.0	45.94	83	80	0.7926	0.7757
8	Iron Powder	1.575	1.686	38.9	45.98	83	79	0.7928	0.7759
9	Molybdenum Powder	1.575	1.686	38.9	45.96	84	80	0.7919	0.7765
10	Nickel Powder	1.574	1.686	38.9	45.96	85	79	0.37917	0.7753
11	Stainless Steel Powder	1.574	1.687	38.9	45.92	86	78	0.7924	0.7757
12	Titanium Metal Powder	1.574	1.687	39.0	45.92	84	79	0.7906	0.7746
13	Zirconium Oxide Powder	1.575	1.686	38.9	45.92	85	80	0.7920	0.7761
14	Control	1.574	1.686	38.5	45.63	86	80	0.7925	0.7771
15	Aluminum Flakes	1.575	1.687	39.0	45.91	84	77	0.7830	0.7685
16	Aluminum Tadpoles	1.576	1.687	39.0	45.96	83	78	0.7876	0.7717
17	Aluminum Flakes	1.576	1.686	38.9	45.92	80	77	0.7829	0.7676
18	Carbon Fibers	1.576	1.687	38.9	45.88	79	74	0.7784	0.7633
19	Control	1.576	1.687	38.7	45.74	82	79	0.7880	0.7737

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In addition to the samples produced above, a number of further samples were produced wherein the size and weight of the cores were reduced and the thickness and weight of the inner cover layers were increased. This can be seen in Sample Nos. 20-23 (below) when the following formulations were utilized and set forth in Table 18.

TABLE 18

	SAMPLE NOS.				
	20	21	22	23a	23
<u>Core Data</u>					
Cariflex 1220	70	70	70	70	70
Taktene 220	30	30	30	30	30
Zinc Oxide	34	20	6	31.5	34
TG Re grind	20	20	20	16	20
Zinc Diacrylate (ZDA)	17.5	18	18.5	20	17.5
Zinc Stearate	15	15	15	16	15
231 XL Peroxide	0.9	0.9	0.9	0.9	0.9
Color	Pink	Blue	Orange	Green	Pink
Size (inches)	1.42	1.42	1.42	1.47	1.42
Weight (grams)	29.4	27.9	26.1	32.5	29.4
S.G.	1.216	1.146	1.073	1.209	1.216
Comp. (Riehle)	130	128	130	106	130
C.O.R.	.757	.767	.772	.765	.757
<u>Mantle Data</u>					
Iotek 1002	50	50	50	50	50
Iotek 1003	50	50	50	50	50
Tungsten	4	26.2	51	—	4
Thickness	0.075"	0.075"	0.075"	0.050"	0.075"
S.G.	0.95	1.19	1.405	0.96	0.98

TABLE 18-continued

	SAMPLE NOS.				
	20	21	22	23a	23
Weight (grams)	38.3	38.2	38.5	38.5	38.2
Comp. (Riehle)	92	93	91	86	92
C.O.R.	.797	.801	.804	.797	.797
<b>Ball Data</b>					
Cover Material	Iotek 8000 19%	Iotek 8000 19%	Iotek 8000 19%	Iotek 8000 19% Iotek 7030 19%	Iotek 7510 42% Iotek 7520 42%
	Iotek 7030 19%	Iotek 7030 19%	Iotek 7030 19%	Iotek 7520 52.4%	Iotek 8000 8.7% Iotek 7030 7.3%
	Iotek 7520 52.4%	Iotek 7520 52.4%	Iotek 7520 52.4%	2810 MB 9.56%	
	2810 MB 9.56%	2810 MB 9.56%	2810 MB 9.56%		
Dimple	422 Tri	422 Tri	422 Tri	422 Tri	422 Tri
Size (inches)	1.684	1.684	1.685	1.684	1.686
Weight (grams)	45.4	45.5	45.6	45.8	45.5
Comp (Riehle)	82	73	83	81	85
C.O.R.	.789	.791	.791	.788	.781
Shore D	57	57	57	57	48

The moment of inertia characteristic of the balls utilized in this Example (i.e., the balls of the invention and commercially available balls) was measured using Moment of Inertia Measuring Instrument Model 5050 made by Inertia Dynamics of Wallingford, Conn. It consists of a horizontal pendulum with a top-mounted cage to hold the ball. The period of oscillation of the pendulum back and forth is a measure of the moment of inertia of the item in the cage. The machine is calibrated using known objects (sphere, cylinder) whose moments are easily calculated or are known.

Actual use of the instrument is as follows. The pendulum is swung with the cage empty. This determines the moment of the machine, less any objects. The ball to be tested is then placed in the cage and the pendulum is swung again. The

period of oscillation will be longer, as the moment of inertia is greater with the ball in the device.

The two periods are used to calculate the moment of inertia of the ball, using the formula:

$$I=194.0*(t^2-T^2)$$

where the 194.0 is the calibration constant for the machine, the T is the period of oscillation of the empty instrument, and t is the period of oscillation of the instrument with the ball loaded.

The following results were obtained and listed in Table 19:

TABLE 19

Ball Type	Sample #	Core Size	Mantle	Additive	phr	Moment of inertia	Ball Size
Multi-Layer	1	1.47	Iotek 1002/1003	Bismuth	5	0.447	1.68
Multi-Layer	2	1.47	Iotek 1002/1003	Boron	5	0.443	1.68
Multi-Layer	3	1.47	Iotek 1002/1003	Brass	5	0.449	1.68
Multi-Layer	4	1.47	Iotek 1002/1003	Bronze	5	0.446	1.68
Multi-Layer	5	1.47	Iotek 1002/1003	Cobalt	5	0.449	1.68
Multi-Layer	6	1.47	Iotek 1002/1003	Copper	5	0.447	1.68
Multi-Layer	7	1.47	Iotek 1002/1003	Inconel	5	0.450	1.68
Multi-Layer	8	1.47	Iotek 1002/1003	Iron	5	0.450	1.68
Multi-Layer	9	1.47	Iotek 1002/1003	Molybdenum	5	0.448	1.68
Multi-Layer	10	1.47	Iotek 1002/1003	Nickel	5	0.452	1.68
Multi-Layer	11	1.47	Iotek 1002/1003	Stainless Steel	5	0.451	1.68
Multi-Layer	12	1.47	Iotek 1002/1003	Titanium	5	0.447	1.68
Multi-Layer	13	1.47	Iotek 1002/1003	Zirconium Oxide	5	0.448	1.68
Multi-Layer	14	1.47	Iotek 1002/1003	None (control)	0	0.441	1.68
Multi-Layer	15	1.47	Iotek 1002/1003	Aluminum Flakes	5	0.449	1.68
Multi-Layer	16	1.47	Iotek 1002/1003	Aluminum Tadpole	5	0.443	1.68
Multi-Layer	17	1.47	Iotek 1002/1003	Aluminum Flakes	5	0.448	1.68
Multi-Layer	18	1.47	Iotek 1002/1003	Carbon Fibers	5	0.443	1.68
Multi-Layer	19	1.47	Iotek 1002/1003	None (control)	0	0.442	1.68
Multi-Layer	20	1.42	Iotek 1002/1003	Tungsten	4	0.436	1.68
Multi-Layer	21	1.42	Iotek 1002/1003	Tungsten	26.2	0.450	1.68
Multi-Layer	22	1.42	Iotek 1002/1003	Tungsten	51	0.460	1.68

TABLE 19-continued

Ball Type	Sample #	Core Size	Mantle	Additive	phr	Moment of inertia	Ball Size
Multi-Layer	23	1.47	Iotek 1002/1003	non (control)	0	0.441	1.68
	Strata Tour	1.47	Hard Ionomer	none	0	0.444	1.68
	Precept Dynawing DC	1.44	Soft Ionomer	Unknown	—	0.433	1.68
Multi-Layer	Wilson Ultra Tour Balata	1.52	Hard Ionomer	TiO2 (as Colorant)	Low	0.453	1.68
Multi-Layer 3 Piece	Precept Tour DC	Wound	Hard Ionomer	TiO2 (as Colorant)	Low	0.405	1.68
3-Piece	Titleist Tour Balata	Wound	None	—	—	0.407	1.68
3-Piece	Titleist Tour Balata	Wound	None	—	—	0.412	1.68
2-Piece	Top Flite XL	1.545	None	—	—	0.445	1.68
2-Piece	Top Flite Z-Balata	1.545	None	—	—	0.448	1.68
2-Piece Oversize	Top Flite Magna	1.545	None	—	—	0.465	1.72
2-Piece Oversize	Top Flite Magna EX	1.57	None	—	—	0.463	1.72

The above results demonstrate that the inclusion of metal particles or other heavy weight filler materials in the inner cover layer produces a higher moment of inertia than the same ball without the materials. This can be seen in comparing Sample Nos. 14 and 19 containing no metal particles in the inner cover layer with Sample Nos. 1–13 and 15–18 containing such heavy weight fillers.

Moreover, as shown in Sample Nos. 20–23, the level of heavy filler present in the inner cover layer is related to the increase in the moment of inertia of the balls. In this regard, Sample No. 20 has 4 parts of tungsten filler compared to the 26.2 and 51 parts found in Sample Nos. 21 and 22, respectively, and the moment of inertia increased accordingly with the filler level.

EXAMPLE 2

A number of golf balls were produced in order to evaluate the effectiveness of transferring the weight of a golf ball from the central core to the inner cover layer. In this regard, four (4) different core formulations (i.e., Core Formulations A–D) were produced wherein the weight in two of the cores, i.e., Core Formulations C and D, was reduced. These formulations were compared to Core Formulation E, the core currently utilized in Spalding's two-piece Top-Flite Z-Balata 100 production ball. These are summarized below in Table 20.

TABLE 20

Materials	Core Formulations				
	A	B	C	D	E
Cariflex 1220	70	70	70	70	70
Taktene 220	30	30	30	30	30
Zinc Oxide	26.7	25	5	5	18
Zinc Stearate	0	0	0	0	20
Zinc Diacrylate (ZDA)	22.5	24	24	22.5	29.7
Stearic Acid	2	2	2	2	0
TG Re grind	16	16	16	16	10.4
231 XL Peroxide	0.9	0.9	0.9	0.9	0.9

TABLE 20-continued

Materials	Core Formulations				
	A	B	C	D	E
Properties					
Size (inches)	1.47"	1.47"	1.47"	1.47"	1.47"
Specific Gravity	1.19	1.17	1.07	1.07	1.15
Weight (grams)	34.4	31.8	29.1	29.3	38.1
Compression (Riehle)	106	83	91	114	78
C.O.R.	.771	.789	.790	.774	.799

As shown above, the weight and/or specific gravity of the core can be decreased (i.e., compare Core Formulations C and D with Core Formulations B and A) without substantially effecting the C.O.R. values of the core. In turn, the effectiveness of increasing the weight of the inner cover layer (or mantle) was evaluated by adding a heavy filler material such as tungsten powder to the inner cover (mantle) formulations. This is shown in the mantle and cover formulations set forth below in Table 21.

TABLE 21

Materials	Mantle and Cover Formulations			
	1	2	3	4
Iotek 8000	50	50	—	33
Iotek 7030	50	50	—	—
Iotek 959	—	—	50	—
Iotek 960	—	—	50	—
Iotek 7510	—	—	—	57.5
TG White MB	—	—	—	9.5
Tungsten Powder	—	62.5	80	—
Zinc Stearate	—	—	50	—

The finished ball properties of the various combinations of core, mantle and outer cover formulations are as follows in Table 22:

TABLE 22

	Sample #24	Sample #25	Sample #26	Sample #27	Sample #28	Sample #29	Sample #30	Sample #31
<u>Core Data</u>								
Type	A	B	C	D	C	D	D	E
Size	1.47"	1.47"	1.47"	1.47"	1.47"	1.47"	1.47"	1.57"
S.G.	1.19	1.17	1.07	1.07	1.07	1.07	1.07	1.15
Weight	32.4	31.8	29.1	29.3	29.1	29.3	29.3	38.1
Comp.	106	83	91	114	91	114	114	78
C.O.R.	.771	.789	.790	.774	.790	.774	.774	.799
<u>Mantle Data</u>								
Mantle Formulation	1	1	1	1	2	2	3	—
Size	1.57	1.57	1.57	1.57	1.57	1.57	1.57	—
S.G.	0.95	0.95	0.95	0.95	1.53	1.53	1.5	—
Weight	37.8	37.6	34.8	34.7	37.8	37.7	37.4	—
Comp.	93	77	83	100	83	100	99	—
C.O.R.	.793	.804	.810	.801	.806	.795	.716— .802	—
<u>Finished Ball Data</u>								
Cover Formulation	4	4	4	4	4	4	4	4
Size	1.681	1.681	1.682	1.682	1.681	1.681	1.681	1.682
S.G.	0.97	0.97	0.97	0.97	0.97	0.97	0.97	0.97
Weight	45	44.8	41.9	41.8	45.1	44.8	44.5	45.4
Comp.	80	69	74	86	74	84	83	76
C.O.R.	.787	.801	.806	.787	.799	.790	.787	.802
Moment of Inertia	0.4338	0.43119	Not Tested	Not Tested	0.454017	0.4491	Not Tested	0.44414

The results indicate that the displacement of weight from the core to the mantle or inner cover layer enhances the moment of inertia of the balls. This is demonstrated particularly in comparing Sample Nos. 24–25 with Sample Nos. 28–30. Accordingly, the formulation of a lighter core with a heavier inner cover or mantle layer produces a ball having an increased moment of inertia.

EXAMPLE 3

Two multi-layer golf balls having relatively thick (about 0.075") inner cover layers (or mantles) containing about ten percent (10%) of powdered brass (Zinc Corp. of America, Monica, Pa.) were prepared and the moment of inertia property of the balls was evaluated. Different solid polybutadiene cores of the same size (i.e., 1.42"), weight (29.7 g) and specific gravity (i.e., 1.2) were utilized but the cores different with respect to compression (Riehle) and C.O.R. The two multi-layer golf balls produced had the following cover properties as shown in Table 23.

TABLE 23

<u>CORE</u>		
Formulations	Sample #32	Sample #33
Cariflex 1220 (High Cis-polybutadiene)	70	70
Taktene 220 (High Cis-polybutadiene)	30	30
Zinc Oxide	31	30.5
TG Re grind (Core re grind)	20	20
Zinc Diacrylate	17.5	18.5
Zinc Stearate	15	15
231 XL Peroxide	0.9	0.9

TABLE 23-continued

<u>Core Data</u>				
Size	1.42"	1.42"		
Weight (grams)	29.7	29.7		
Comp (Riehle)	124	117		
C.O.R.	.765	.770		
Spec. Grav.	1.2	1.2		
<u>MANTLE</u>				
Formulations	Modulus	Spec. Grav.	Sample #32	Sample #33
Iotek 1002	380 MPa	0.95	45	45
Iotek 1003	147 MPa	0.95	45	45
Powdered Brass	—	8.5	10	10
Blend Modulus (Estimated)			264 MPa	264 MPa
Spec Grav. Blend			1.05	1.05
<u>Mantle Data</u>				
Size			1.57"	1.57"
Thickness			0.075"	0.075"
Weight (grams)			38.4	38.4
Comp (Riehle)			92	84
C.O.R.			.795	.800
Shore C/D			97/70	97/70
<u>COVER</u>				
Formulation	Modulus	Sample #32	Sample #33	
Iotek 7510	35 MPa	58.9	58.9	
Iotek 8000	320 MPa	33.8	33.8	
Iotek 7030	155 MPa	7.3	7.3	
Blend Modulus (Estimated)		140 MPa	140 MPa	
Spec. Grav. Blend		0.98	0.98	
Whitener Package				
Unitane 0–110		2.3 phr	2.3 phr	

TABLE 23-continued

Eastobrite OB-1	0.025 phr	0.025 phr	
Ultra Marine Blue	0.042 phr	0.042 phr	
Santonox R	0.004 phr	0.004 phr	5
Ball Data			
Size	1.68"	1.68"	
Cover Thickness	0.055"	0.055"	
Weight	45.5	45.5	
Comp (Riehle)	80	76	
C.O.R.	.785	.790	10
Shore C/D	87/56	87/56	
Moment of Inertia	0.445	0.445	

The above multi-layer balls of the present invention having a thick inner cover layer (or mantle) comprising a blend of high acid ionomer resins and about 10% of a heavy weight filler material over a soft cross-linked polybutadiene core with a cover layer of soft thermoplastic material, exhibited an increased moment of inertia. This can be seen by comparing the moment of inertia of the control balls of Example 1 (i.e., Sample Nos. 14, 19 and 23) which possessed a moment of inertia of approximately 0.441 and the balls of the invention above (i.e., Sample Nos. 32-33) which exhibited a moment of inertia of 0.445.

EXAMPLE 4

The effects produced by increasing the moment of inertia and increasing the inner cover layer thickness of a multi-layer golf ball was observed by comparing a multi-layer golf ball produced by the present invention (i.e., "Strata Distance 90-EX") with a commercially available multi-layer golf ball sold by Spalding under the designation "Strata Tour 90". The "Strata Distance 90-EX" ball contains a thick high acid ionomer resin inner cover layer over a soft cross-linked polybutadiene core with an outer cover layer of soft ionomer resin. Further, the mantle or inner cover layer is filled with 5 phr of powdered tungsten.

In addition, the spin and distance characteristics of the multi-layer golf balls were also compared with Spalding's "Top-Flite Z-Balata 90" golf ball (a 1.68", two-piece ball having a soft ionomer resin cover) and Acushnet Company's "Titleist Tour Balata 100" golf ball (a 1.68", two-piece ball having a soft synthetic balata cover). The distance and spin characteristics were determined according to the following parameters:

Three balls of each type being tested are checked for static data to insure they are within reasonable limits individually for size, weight, compression and coefficient. They must, at the least, be reasonably similar to one another for static data.

A stripe is placed around a great circle of the ball to create a visual equator which is used to measure the spin rate in the photographs. The balls are hit a minimum of three times each ball, so that for a given type, there will be nine hits to yield information on the launch angle, ball speed and spin rate. Further, the balls are hit in random order to randomize effects due to machine variations.

A strobe light is used to produce up to 10 images of the ball's flight on Polaroid film. The strobe is controlled by a computer based counter timer board running with a clock rate of 100,000 Hertz. This means that the strobed images of the ball are known in time to within 1/100,000 second.

In each picture, in the field of view, is a reference system giving a level line reference and a length reference.

Each picture is digitized on a 1000 lines per inch resolution digitizing tablet, giving positions of the reference and the stripes on the multiple images of the balls. From this information, the ball speed, launch angle and spin rate can be obtained.

A #9 iron with the following specifications is used for the test: 1984 Tour Edition Custom Crafted 9 Iron with V grooves, 140 pitch. The shaft is a Dynamic Gold R3. The club has a D2.0 swing weight, length of 35 7/8 inches, lie of 62 degrees, with face angle at 0, the loft is 47 1/2 degrees. The club's overall weight is 453 grams. The grip is an Eaton Green Victory M60 core grip.

The club is held in the "wrist" mechanism of the Miya Epoch Robo III Driving Machine so that the machine will strike the ball squarely, driving the ball straight away from the tee in line with the swing of the club. The machine is manufactured by Miya Epoch of America, Inc., 2468 W. Torrance Blvd., Torrance, Calif. 90501. A line is drawn along the base of the machine, extending out along the direction of the hit ball. The ball impacts a stopping curtain of Kevlar 8-10 feet downrange, and a square shot is one in which the direction of the ball from the tee is parallel to the line drawn along the front base of the driving machine.

Average ball speed of all types together should be around 100-125 feet per second, and launch angle should be around 26 to 34 degrees.

During testing the following characteristics were noted and listed in Table 24:

TABLE 24

Test Conditions: (test #92461)						
Club: 10 Degree Driver		Ball Speed: 227.1 fps				
Club Head Speed: 16 fps		Spin Rate: 3033 rpm				
Launch angle: 9.1		Turf Conditions: Firm				
<u>SPIN RESULTS (RPM)</u>						
<u>DISTANCE RESULTS</u>						
					9 Iron @	9 Iron @
Ball Type	Traj.	Carry	Roll	Total	125 fps	63 fps
Strata Tour 90	15	250.7	5.2	255.8	9273	5029
Z-Balata 90	15.1	250.6	1.3	255.4	9314	4405
Strata						
Distance 90-EX	15.5	254.4	1.4	258.1	9033	4308
Titleist Tour	14.8	247.6	0.7	250.7	10213	4978
Balata 100						

The results indicate that the increase produced in the moment of inertia by enlarging the thickness and weight of the inner cover layer while reducing the weight and size of the core resulted in a multi-layer ball (i.e., the Strata Distance 90-EX) having less spin and farther distance than the existing multi-layer golf ball (i.e., Strata Tour 90). Furthermore, the results indicate that the ball of the present invention traveled farther than other commercially available high spinning golf balls.

The invention has been described with reference to the preferred embodiments. Obviously, modifications and alterations will occur to others upon reading and understanding the proceeding detailed description. It is intended that the invention be construed as including all such modifications and alterations insofar as they come within the scope of the appended claims or the equivalents thereof.

What is claimed is:

1. A golf ball comprising:

- a core comprising a non-phosphorescent material;
- a cover assembly disposed about said core, said cover assembly defining an outer surface of said ball having

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a plurality of dimples and a recessed region along said outer surface of said ball; and

a viewing window disposed in said recessed region.

2. The golf ball of claim 1 wherein said cover assembly comprises a polymeric material and particulate weighting material dispersed therein.

3. The golf ball of claim 2 wherein said particulate weighting material is a powdered metal.

4. The golf ball of claim 1 wherein said viewing window is generally transparent.

5. The golf ball of claim 1 wherein said cover assembly includes an inner cover layer and an outer cover layer, said inner cover layer comprising particulate weighting material serving to increase the moment of rotational inertia of said ball, and said outer cover layer defining said outer surface of said ball and said recessed region along said outer surface of said ball.

6. The golf ball of claim 5 wherein said particulate weighting material is visible from the exterior of said golf ball through said viewing window.

7. The golf ball of claim 5 wherein said particulate weighting material is disposed radially inward from said viewing window.

8. A golf ball comprising:

a core;

a first cover layer disposed about said core, said first cover layer comprising a particulate weighting material;

a second cover layer disposed about said first cover layer, said second cover layer defining an outer surface of said golf ball and further defining a recessed region along said outer surface of said golf ball; and

a viewing window disposed in said recessed region, said viewing window being generally transparent and enabling at least a portion of said particulate weighting material in said first cover layer to be visible from said outer surface of said golf ball.

9. The golf ball of claim 8 wherein said second cover layer defines a plurality of recessed regions along said outer surface of said golf ball, and said golf ball further comprises a plurality of viewing windows, each disposed in one of said recessed regions.

10. The golf ball of claim 8 wherein said particulate weighting material comprises powdered metal.

11. A golf ball comprising:

a core;

a first cover layer disposed about said core, said first cover layer including particulate weighting material; and

a second cover layer disposed on said first cover layer, said second cover layer defining an outer dimpled surface of said golf ball and having a first opaque portion and a second generally transparent portion,

wherein said particulate weighting material in said first cover layer is visible through said second portion of said second cover layer from the exterior of said golf ball.

12. The golf ball of claim 11 wherein said particulate weighting material includes powdered metal.

13. A method of producing a golf ball having a viewing window along the outer surface of said golf ball, said method comprising:

providing an intermediate golf ball component;

providing a preformed window component;

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positioning and affixing said preformed window component on said intermediate golf ball component;

forming a cover layer over said intermediate golf ball component and generally about said window component to thereby produce said golf ball having said viewing window.

14. The method of claim 13 wherein said preformed window component is generally transparent and said cover layer is opaque or substantially so.

15. A method of producing a golf ball having a viewing window along the outer surface of said golf ball, said method comprising:

providing an intermediate golf ball component;

molding a viewing window on said intermediate golf ball component; and

forming a cover layer over said intermediate golf ball component and generally about said viewing window to thereby produce said golf ball having said viewing window.

16. The method of claim 15 wherein said viewing window is generally transparent and said cover layer is opaque or substantially so.

17. A method of producing a golf ball having a viewing window along the outer surface of said golf ball, said method comprising:

providing an intermediate golf ball component;

providing a window insert;

positioning said window insert on said intermediate golf ball component;

forming a cover layer over said intermediate golf ball component and about said window insert;

removing said window insert thereby leaving a void within said cover layer;

depositing window material in said void;

molding said window material to thereby form said viewing window and thereby produce said golf ball having a viewing window along the outer surface of said golf ball.

18. The method of claim 17 wherein said viewing window is generally transparent and said cover layer is opaque or substantially so.

19. A method of producing a golf ball having a viewing window along the outer surface of said golf ball, said method comprising:

providing an intermediate golf ball component;

providing a window insert;

positioning said window insert on said intermediate golf ball component;

forming a cover layer over said intermediate golf ball component and about said window insert;

removing said window insert thereby leaving a void within said cover layer;

providing a preformed viewing window;

positioning and affixing said preformed window in said void to thereby produce said golf ball having a viewing window along the outer surface of said golf ball.

20. The method of claim 19 wherein said viewing window is generally transparent and said cover layer is opaque or substantially so.

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